

INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

<p>(51) International Patent Classification<sup>6</sup> : <b>C11D 1/40, 1/44</b></p>	<p><b>A1</b></p>	<p>(11) International Publication Number: <b>WO 98/13449</b> (43) International Publication Date: <b>2 April 1998 (02.04.98)</b></p>
<p>(21) International Application Number: <b>PCT/US97/17077</b> (22) International Filing Date: <b>22 September 1997 (22.09.97)</b> (30) Priority Data: <b>9619921.1 24 September 1996 (24.09.96) GB</b> (71) Applicant (for all designated States except US): <b>THE PROCTER &amp; GAMBLE COMPANY [US/US]; One Procter &amp; Gamble Plaza, Cincinnati, OH 45202 (US).</b> (72) Inventors; and (75) Inventors/Applicants (for US only): <b>ASKEW, Stuart, Clive [GB/GB]; 17 Mayfair Road, West Jesmond, Newcastle upon Tyne NE2 3DN (GB). SORRIE, Graham, Alexander [GB/GB]; 14 Curley Hill, Lancaster Park, Morpeth, Northumberland NE61 3SH (GB). HALL, Robin, Gibson [GB/GB]; 27 Blackfriars Court, Stowell Street, Newcastle upon Tyne NE1 4XB (GB).</b> (74) Agents: <b>REED, T., David et al.; The Procter &amp; Gamble Company, 5299 Spring Grove Avenue, Cincinnati, OH 45217 (US).</b></p>		<p>(81) Designated States: <b>AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, GH, HU, ID, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, US, UZ, VN, YU, ZW, ARIPO patent (GH, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).</b>  <b>Published</b> <i>With international search report. Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i></p>
<p>(54) Title: <b>DETERGENT COMPOSITIONS</b> (57) Abstract  The present invention relates to granular detergent compositions or components thereof, which comprise a hydrophobic organic peroxyacid bleaching system, capable of providing a hydrophobic organic peroxyacid compound and one or more cationic compounds, which are cationic, (partially) quaternized ethoxylated (poly)amine compounds with clay-soil removal/anti-redeposition properties, for use in laundry and dishwashing processes.</p>		

**FOR THE PURPOSES OF INFORMATION ONLY**

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TC	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece	ML	Mali	TR	Turkey
BG	Bulgaria	HU	Hungary	MN	Mongolia	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MR	Mauritania	UA	Ukraine
BR	Brazil	IL	Israel	MW	Malawi	UG	Uganda
BY	Belarus	IS	Iceland	MX	Mexico	US	United States of America
CA	Canada	IT	Italy	NK	Niger	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NL	Netherlands	VN	Viet Nam
CG	Congo	KE	Kenya	NO	Norway	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NZ	New Zealand	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	PL	Poland		
CM	Cameroon	KR	Republic of Korea	PT	Portugal		
CN	China	KZ	Kazakhstan	RO	Romania		
CU	Cuba	LC	Saint Lucia	RU	Russian Federation		
CZ	Czech Republic	LI	Liechtenstein	SD	Sudan		
DE	Germany	LK	Sri Lanka	SE	Sweden		
DK	Denmark	LR	Liberia	SG	Singapore		
EE	Estonia						

## **Detergent Compositions**

### **Technical Field**

The present invention relates to granular detergent compositions or components thereof containing cationic compounds with particulate/clay-soil removal/anti-redeposition properties and a hydrophobic organic peroxyacid bleaching system for use in laundry and dish washing processes.

### **Background to the Invention**

A particularly important property of a detergent composition is its ability to remove particulate type soils from a variety of fabrics during laundering. Perhaps the most important particulate soils are the clay-type soils. Clay soil particles generally comprise negatively charged layers of aluminosilicates and positively charged cations (e.g. calcium) which are positioned between and hold together the negatively charged layers.

A variety of models can be proposed for compounds which would have particulate/ clay-soil removal properties. One model requires that the compound have two distinct characteristics. The first is the ability of the compound to adsorb onto the negatively charged layers of the clay particle. The second is the ability of the compound, once adsorbed, to push apart (swell) the negatively charged layers so that the clay particle loses its cohesive force and can be removed in the wash water.

In addition to clay soil removal, there is a need to keep the removed soil in suspension during the laundering (or dish washing) cycle. Soil which is removed from the fabric and suspended in the wash water can redeposit on the surface of the fabric. This redeposited soil causes a dulling or "greying" effect which is especially noticeable on white fabrics. To minimise this problem, anti-redeposition agents can be included in the detergent composition.

For example EP-B-111 965 disclose the use in detergents of cationic compounds, which have both clay-soil removal and anti-redeposition properties.

US 4,659,802 and US 4,664,848 describe quaternized amines which have clay-soil removal and anti-redeposition properties and which can be used in combination with anionic surfactants.

A model proposed for the anti-redeposition action of the positively charged anti-redeposition compounds is as follows. Adsorption of the positively charged molecule on the surface of clay particles in the wash water gives the particles the dispersancy properties of the molecule. As more and more of these compounds adsorb onto the suspended clay soil particles, the latter become encased within a hydrophilic layer provided by the attached ethoxy units. As such the hydrophilically encased soil is prevented from redepositing on fabrics, in particular hydrophobic fabrics such as polyester, during the laundering or dish washing cycle.

Another component traditionally used in detergent is bleach, to remove bleachable stains or soils from the fabric.

A disadvantage of the use of most bleaches is that various other detergent components are bleach sensitive and that they can be oxidised by the bleach, whereby their original properties can be diminished. Thus, not all detergent components are bleach- compatible.

The Applicants have found that cationic, (partially) quaternized ethoxylated (poly) amines which have clay-soil removal/anti-redeposition properties, are fully compatible with bleaches formulated therewith.

It also has been found that the use in detergent compositions (or components thereof) of (oxygen-releasing) bleach in combination with fully quaternised ethoxylated (poly) amines provides a better improvement in cleaning or whiteness maintenance than the use of (oxygen releasing) bleach in combination with partially quaternised ethoxylated (poly) amines. However, even the partially quaternised ethoxylated (poly) amines provide an improvement in cleaning or whiteness maintenance in combination with bleach.

Without wishing to be bound by theory, the bleach-compatibility of the cationic, quaternized ethoxylated (poly) amines can be explained as follows. The quaternization of the nitrogen groups of these molecules is believed to have a dual purpose. It provides a cationic charge on the molecule, improving adsorption onto clay particles either on the fabric surface or dispersed in wash water, and it removes the oxidisable lone pair on the nitrogen groups from attack by bleaching species, thus making the molecule stable in a bleach containing laundry detergents.

Recently developed bleach species are bleaching systems based on hydrophobic peroxyacids.

It has been found that a problem with hydrophobic bleaches is that despite their tendency to migrate to the (hydrophobic) fabric surface, they do not necessarily interact fully with the bleachable stain or soil components. It has been found that the hydrophobic bleaches can be prevented from migration onto hydrophobic bleachable stains/soils by deposited clay-soil particulates on the fabric. Thereby, their bleaching performance can be diminished. This results in a lessening of the bleachable/ dingy soil cleaning performance of the hydrophobic bleach.

The Applicants have found that this problem can be ameliorated by the inclusion of one or more which have clay-soil removal/anti-redeposition properties (as mentioned above) in a detergent composition, comprising a hydrophobic bleach. It has been found that in detergent compositions comprising both components the bleach efficacy of the hydrophobic organic peroxyacid bleaching system is enhanced. Thereby, the overall cleaning performance of the detergent is improved, which is especially noticeable on fabric stained with organic clay-soil particules, such as peat stains.

All documents cited in the present description are, in relevant part, incorporated herein by reference.

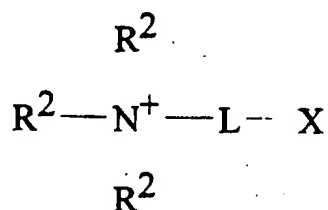
Summary of the invention

The present invention relates to granular detergent compositions or components thereof, which comprise a hydrophobic organic peroxyacid bleaching system, capable of providing a hydrophobic organic peroxyacid compound and one or more cationic compounds, which are cationic, (partially) quaternized ethoxylated (poly) amine compounds with particulate/ clay-soil removal / anti-redeposition properties.

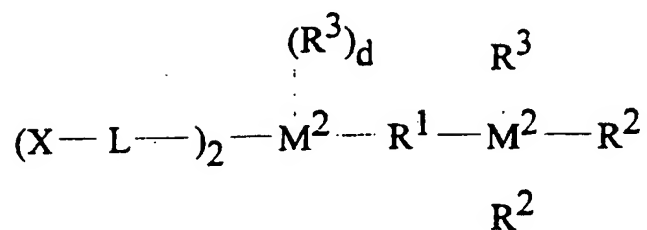
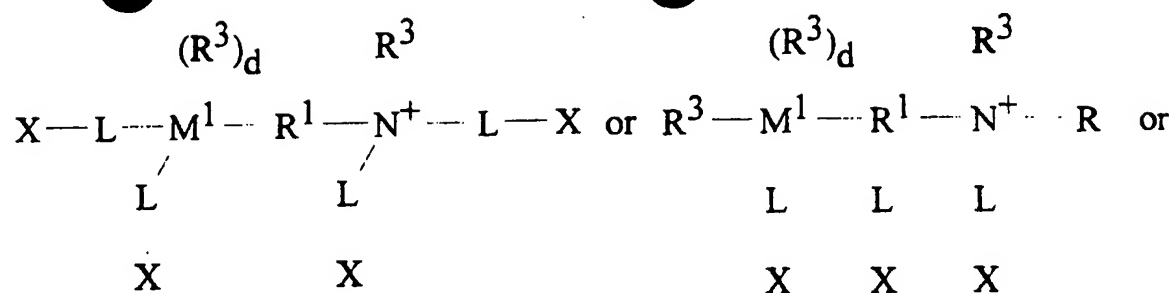
In more detail, the present invention relates to granular detergent compositions or components thereof, which comprise

- (a) a hydrophobic organic peroxyacid bleaching system, capable of providing a hydrophobic organic peroxyacid compound; and
- (b) a water-soluble cationic compound having clay soil removal/anti-redeposition properties, which is selected from the group consisting of:

- 1) ethoxylated cationic monoamines having the formula:

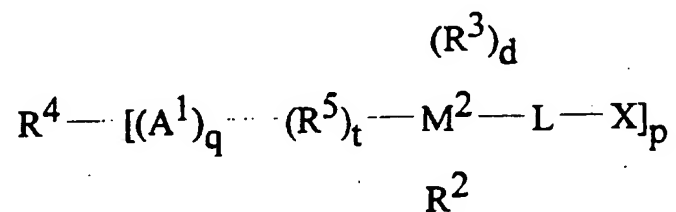


- 2) ethoxylated cationic diamines having the formula:

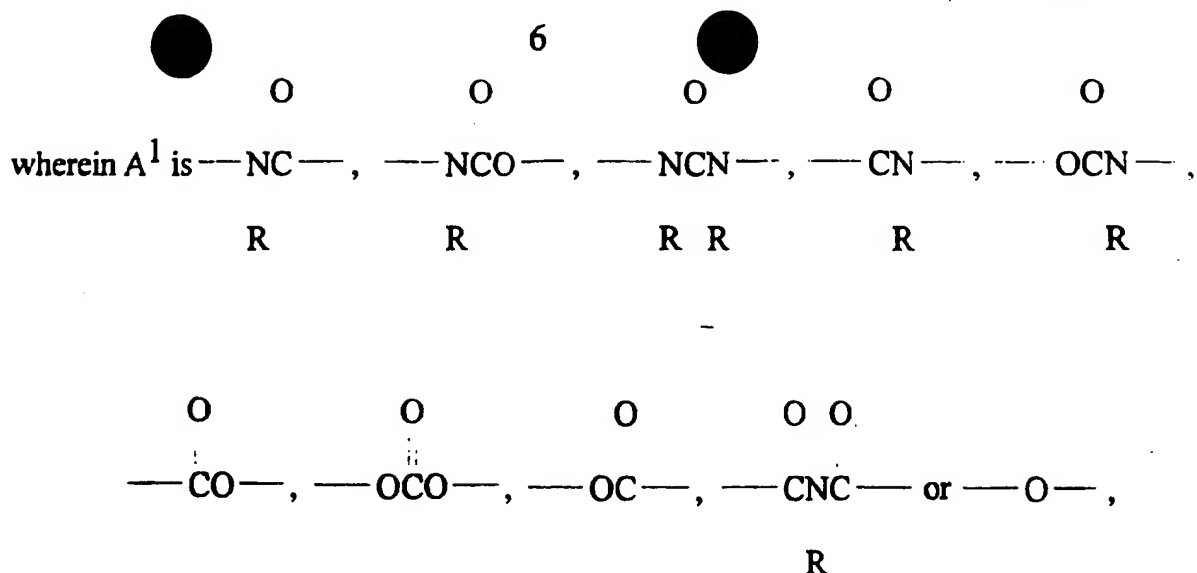


wherein M<sup>1</sup> is an N<sup>+</sup> or N group; each M<sup>2</sup> is an N<sup>+</sup> or N group,  
and at least one M<sup>2</sup> is an N<sup>+</sup> group;

3) ethoxylated cationic polyamines having the formula:



4) mixtures thereof;



R is H or C<sub>1</sub>-C<sub>4</sub> alkyl or hydroxyalkyl, R<sup>1</sup> is C<sub>2</sub>-C<sub>12</sub> alkylene, hydroxyalkylene, alkenylene, arylene or alkarylene, or a C<sub>2</sub>-C<sub>3</sub> oxyalkylene moiety having from 2 to about 20 oxyalkylene units provided that no O-N bonds are formed; each R<sup>2</sup> is C<sub>1</sub>-C<sub>4</sub> alkyl or hydroxyalkyl, the moiety -L-X, or two R<sup>2</sup> together form the moiety -(CH<sub>2</sub>)<sub>r</sub>-A<sup>2</sup>-(CH<sub>2</sub>)<sub>s</sub>-, wherein A<sup>2</sup> is -O- or -CH<sub>2</sub>-, r is 1 or 2, s is 1 or 2 and r + s is 3 or 4; each R<sup>3</sup> is C<sub>1</sub>-C<sub>8</sub> alkyl or hydroxyalkyl, benzyl, the moiety L-X, or two R<sup>3</sup> or one R<sup>2</sup> and one R<sup>3</sup> together form the moiety -(CH<sub>2</sub>)<sub>r</sub>-A<sup>2</sup>-(CH<sub>2</sub>)<sub>s</sub>-, R<sup>4</sup> is a substituted C<sub>3</sub>-C<sub>12</sub> alkyl, hydroxyalkyl, alkenyl, aryl or alkaryl group having p substitution sites; R<sup>5</sup> is C<sub>1</sub>-C<sub>12</sub> alkenyl, hydroxyalkylene, alkenylene, arylene or alkarylene, or a C<sub>2</sub>-C<sub>3</sub> oxyalkylene moiety having from 2 to about 20 oxyalkylene units provided that no O-O or O-N bonds are formed; X is a nonionic group selected from the group consisting of H, C<sub>1</sub>-C<sub>4</sub> alkyl or hydroxyalkyl ester or ether groups, and mixtures thereof; L is a hydrophilic chain which contains the polyoxyalkylene moiety

$-(R^6O)_m(CH_2CH_2O)_n-$ ; wherein R<sup>6</sup> is C<sub>3</sub>-C<sub>4</sub> alkylene or hydroxyalkylene and m and n are numbers such that the moiety  $-(CH_2CH_2O)_n-$  comprises at least about 50% by weight of said polyoxyalkylene moiety; d is 1 when M<sup>2</sup> is N<sup>+</sup> and is 0 when M<sup>2</sup> is N; n is at least about 16 for said cationic monoamines, is at least about 6 for said cationic diamines and is at least about 3 for said cationic polyamines; p is from 3 to 8; q is 1 or 0; t is 1 or 0, provided that t is 1 when q is 1.



In a preferred aspect said hydrophobic organic peroxyacid bleaching system comprises (i) a hydrogen peroxide source and (ii) a hydrophobic organic peroxyacid bleach precursor compound.

### Detailed description of the invention

An essential feature of the present invention is a water-soluble cationic compound which has particulate/ clay-soil removal/anti-redeposition properties and which is selected from the group consisting of cationic mono-di- and polyamines.

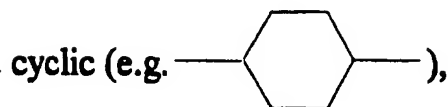
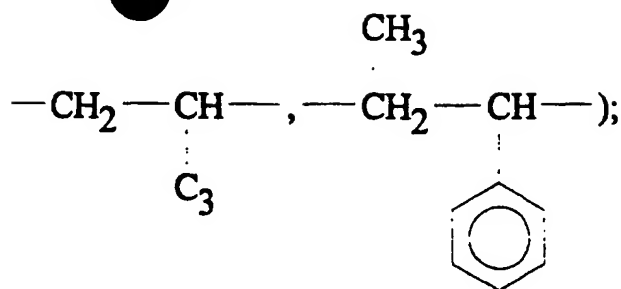
In detergent compositions, the water-soluble cationic compound is preferably present at a level of from 0.01 % to 30%, more preferably from 0.1 % to 15% , most preferably from 0.2 % to 3.0% by weight of the detergent composition.

### Cationic amines

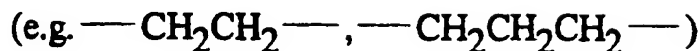
The water-soluble cationic compounds of the present invention useful in the granular detergent compositions or components thereof in accord with the present invention include ethoxylated cationic monoamines, ethoxylated cationic diamines and ethoxylated cationic polyamines as previously defined.

In the preceding formulas for the cationic amines,  $R^1$  can be branched

(e.g.



or most preferably linear



alkylene, hydroxyalkylene, alkenylene, alkarylene or oxyalkylene.  $\text{R}^1$  is preferably  $\text{C}_2$ - $\text{C}_6$  alkylene for the ethoxylated cationic diamines. Each  $\text{R}^2$  is preferably methyl or the moiety  $-\text{L}-\text{X}$ ; each  $\text{R}^3$  is preferably  $\text{C}_1$ - $\text{C}_4$  alkyl or hydroxyalkyl, and most preferably methyl.

The positive charge of the  $\text{N}^+$  groups is offset by the appropriate number of counter anions. Suitable counter anions include  $\text{Cl}^-$ ,  $\text{Br}^-$ ,  $\text{SO}_3^{2-}$ ,  $\text{PO}_4^{2-}$ ,  $\text{MeOSO}_3^-$  and the like. Particularly preferred counter anions are  $\text{Cl}^-$  and  $\text{Br}^-$ .

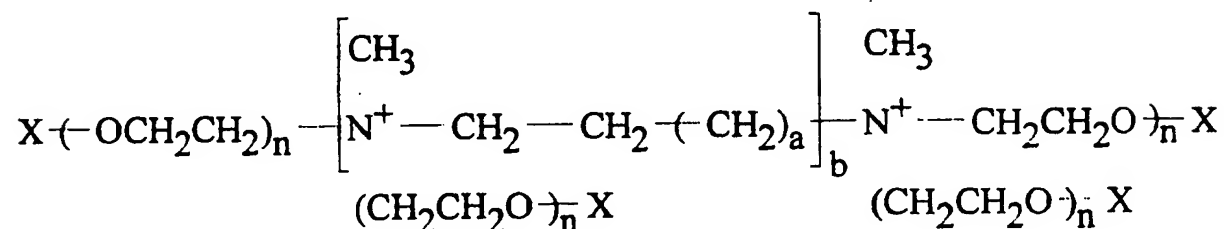
$\text{X}$  can be a nonionic group selected from hydrogen ( $\text{H}$ ),  $\text{C}_1$ - $\text{C}_4$  alkyl or hydroxyalkyl ester or ether groups, or mixtures thereof. Preferred esters or ethers are the acetate ester and methyl ether, respectively. The particularly preferred nonionic groups are  $\text{H}$  and the methyl ether.

In the preceding formulas, hydrophilic chain  $\text{L}$  usually consists entirely of the polyoxyalkylene moiety  $-(\text{R}^6\text{O})_m(\text{CH}_2\text{CH}_2\text{O})_n-$ . The moieties  $-(\text{R}^6\text{O})_m-$  and  $-(\text{CH}_2\text{CH}_2\text{O})_n-$  of the polyoxyalkylene moiety can be mixed together or preferably form blocks of  $-(\text{R}^6\text{O})_m-$  and  $-(\text{CH}_2\text{CH}_2\text{O})_n-$  moieties.  $\text{R}^6$  is preferably  $\text{C}_3\text{H}_6$  (propylene);  $m$  is preferably from 0 to about 5 and is most preferably 0, i.e. the polyoxyalkylene moiety consists

entirely of the moiety  $-(CH_2CH_2O)_n-$ . The moiety  $-(CH_2CH_2O)_n-$  preferably comprises at least about 85% by weight of the polyoxyalkylene moiety and most preferably 100% by weight (m is 0).

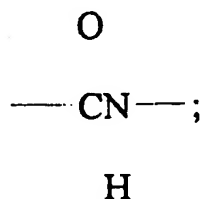
In the preceding formulas,  $M^1$  and each  $M^2$  are preferably an  $N^+$  group for the cationic diamines and polyamines.

Preferred ethoxylated cationic monoamines and diamines have the formula:



wherein X and n are defined as before, a is from 0 to 20, preferably 0 to 4 (e.g. ethylene, propylene, hexamethylene) b is 1 or 0. For preferred cationic monoamines (b=0), n is preferably at least about 16, with a typical range of from about 20 to about 35. For preferred cationic diamines (b=1), n is at least about 12 with a typical range of from about 12 to about 42.

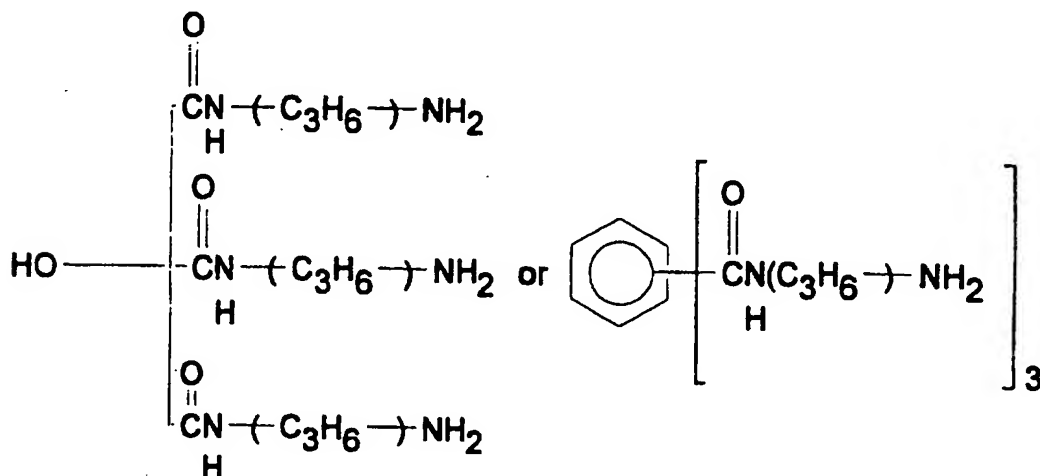
In the preceding formula for the ethoxylated cationic polyamines,  $R^4$  (linear, branched, or cyclic) is preferably a substituted  $C_3$ - $C_6$  alkyl, hydroxyalkyl or aryl group;  $A^1$  is preferably



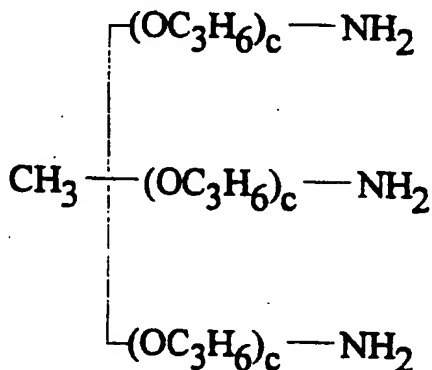
n is preferably at least about 12, with a typical range of from about 12 to about 42; p is preferably from 3 to 6. When  $R^4$  is a substituted aryl or alkaryl group, q is preferably 1 and  $R^5$  is preferably  $C_2$ - $C_3$  alkylene. When  $R^4$  is a substituted alkyl, hydroxyalkyl, or alkenyl

group, and when q is 0, R<sup>5</sup> is preferably a C<sub>2</sub>-C<sub>3</sub> oxyalkylene moiety; when q is 1, R<sup>5</sup> is preferably C<sub>2</sub>-C<sub>3</sub> alkylene.

These ethoxylated cationic polyamines can be derived from polyamino amides such as:



These ethoxylated cationic polyamines can also be derived from polyaminopropyleneoxide derivatives such as:



wherein each c is a number from 2 to about 20.

### Hydrophobic organic peroxyacid bleaching system

An essential feature of detergent compositions or components thereof in accord with the invention is a hydrophobic organic peroxyacid bleaching system, capable of providing a hydrophobic organic peroxyacid compound. By hydrophobic organic peroxyacid compound

it is meant herein an organic peroxyacid whose parent carboxylic acid has a critical micelle concentration less than 0.5 moles/litre and wherein said critical micelle concentration is measured in aqueous solution at 20°-50°C.

Preferably the hydrophobic organic peroxyacid bleaching system comprises a hydrogen peroxide source and a hydrophobic organic peroxyacid bleach precursor compound. The production of the hydrophobic organic peroxyacid occurs by an in situ reaction of the precursor with a source of hydrogen peroxide. Preferred sources of hydrogen peroxide include inorganic perhydrate bleaches. In an alternative preferred execution the hydrophobic organic peroxyacid bleaching system comprises a preformed hydrophobic organic peroxyacid, which is incorporated directly into the composition. Compositions containing mixtures of a hydrogen peroxide source and hydrophobic organic peroxyacid precursor in combination with a preformed hydrophobic organic peroxyacid are also envisaged.

Preferably, the hydrophobic organic peroxyacid contains at least 7 carbon atoms, more preferably at least 9 carbon atoms, most preferably at least 11 carbon atoms. In a preferred aspect the peroxyacid has an alkyl chain comprising at least 7 carbon atoms, more preferably at least 8 carbon atoms, most preferably at least 9 carbon atoms.

#### Inorganic perhydrate bleaches

Inorganic perhydrate salts are a preferred source of hydrogen peroxide. These salts are normally incorporated in the form of the alkali metal, preferably sodium salt at a level of from 1% to 40% by weight, more preferably from 2% to 30% by weight and most preferably from 5% to 25% by weight of the compositions.

Examples of inorganic perhydrate salts include perborate, percarbonate, perphosphate, persulfate and persilicate salts. The inorganic perhydrate salts are normally the alkali metal salts. The inorganic perhydrate salt may be included as the crystalline solid

without additional protection. For certain perhydrate salts however, the preferred executions of such granular compositions utilise a coated form of the material which provides better storage stability for the perhydrate salt in the granular product. Suitable coatings comprise inorganic salts such as alkali metal silicate, carbonate or borate salts or mixtures thereof, or organic materials such as waxes, oils, or fatty soaps.

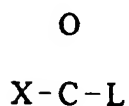
Sodium perborate is a preferred perhydrate salt and can be in the form of the monohydrate of nominal formula  $\text{NaBO}_2\text{H}_2\text{O}_2$  or the tetrahydrate  $\text{NaBO}_2\text{H}_2\text{O}_2 \cdot 3\text{H}_2\text{O}$ .

Alkali metal percarbonates, particularly sodium percarbonate are preferred perhydrates herein. Sodium percarbonate is an addition compound having a formula corresponding to  $2\text{Na}_2\text{CO}_3 \cdot 3\text{H}_2\text{O}_2$ , and is available commercially as a crystalline solid.

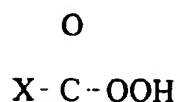
Potassium peroxymonopersulfate is another inorganic perhydrate salt of use in the detergent compositions herein.

#### Peroxyacid bleach precursor

Peroxyacid bleach precursors are compounds which react with hydrogen peroxide in a perhydrolysis reaction to produce a peroxyacid. Generally peroxyacid bleach precursors may be represented as



where L is a leaving group and X is essentially any functionality, such that on perhydrolysis the structure of the peroxyacid produced is



For the purposes of the present invention X will thus contain at least 6 carbon atoms.

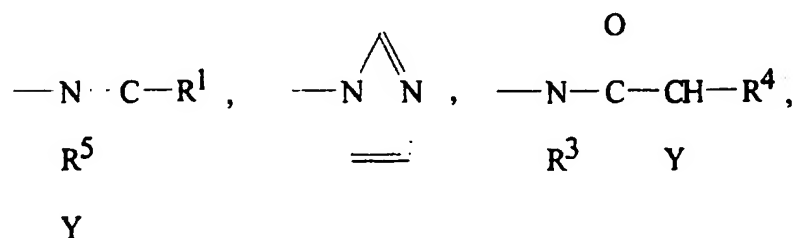
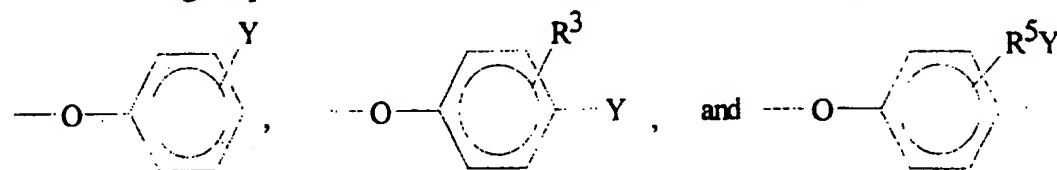
The hydrophobic peroxyacid bleach precursor compounds are preferably incorporated at a level of from 0.05 % to 20 % by weight, more preferably from 0.1 % to 15 % by weight, most preferably from 0.2 % to 10 % by weight of the detergent compositions.

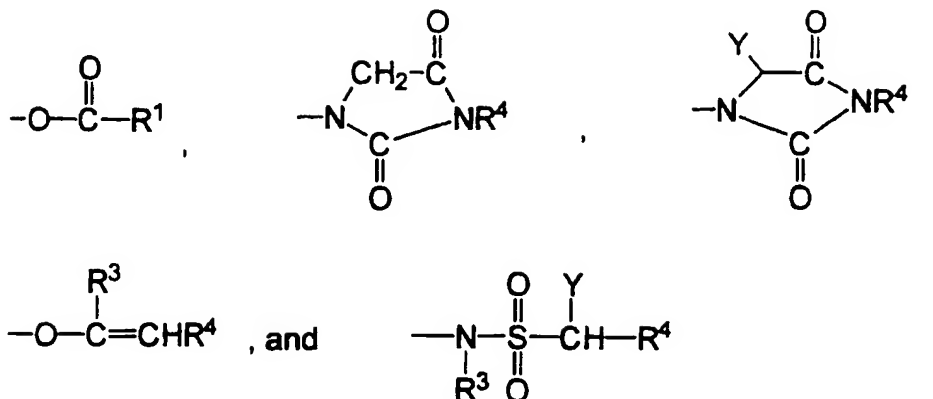
Suitable hydrophobic peroxyacid bleach precursor compounds typically contain one or more N- or O-acyl groups, which precursors can be selected from a wide range of classes. Suitable classes include anhydrides, esters, imides, lactams and acylated derivatives of imidazoles and oximes. Examples of useful materials within these classes are disclosed in GB-A-1586789. Suitable esters are disclosed in GB-A-836988, 864798, 1147871, 2143231 and EP-A-0170386.

### Leaving groups

The leaving group, hereinafter L group, must be sufficiently reactive for the perhydrolysis reaction to occur within the optimum time frame (e.g., a wash cycle). However, if L is too reactive, this activator will be difficult to stabilize for use in a bleaching composition.

Preferred L groups are selected from the group consisting of:





and mixtures thereof, wherein  $\text{R}^1$  is an alkyl, aryl, or alkaryl group containing from 1 to 14 carbon atoms,  $\text{R}^3$  is an alkyl chain containing from 1 to 8 carbon atoms,  $\text{R}^4$  is H or  $\text{R}^3$ ,  $\text{R}^5$  is an alkylene chain containing from 1 to 8 carbon atoms and Y is H or a solubilizing group. Any of  $\text{R}^1$ ,  $\text{R}^3$  and  $\text{R}^4$  may be substituted by essentially any functional group including, for example alkyl, hydroxy, alkoxy, halogen, amine, nitrosyl, amide and ammonium or alkyl ammonium groups

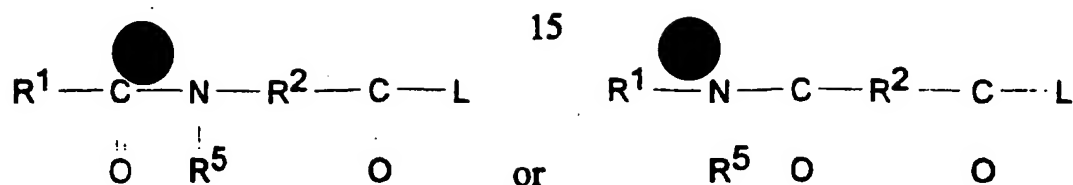
The preferred solubilizing groups are  $-\text{SO}_3^- \text{M}^+$ ,  $-\text{CO}_2^- \text{M}^+$ ,  $-\text{SO}_4^- \text{M}^+$ ,  $-\text{N}^+ (\text{R}^3)_4 \text{X}^-$  and  $\text{O} < -\text{N} (\text{R}^3)_3$  and most preferably  $-\text{SO}_3^- \text{M}^+$  and  $-\text{CO}_2^- \text{M}^+$

wherein  $\text{R}^3$  is an alkyl chain containing from 1 to 4 carbon atoms, M is a cation which provides solubility to the bleach activator and X is an anion which provides solubility to the bleach activator. Preferably, M is an alkali metal, ammonium or substituted ammonium cation, with sodium and potassium being most preferred, and X is a halide, hydroxide, methylsulfate or acetate anion.

#### Amide substituted alkyl peroxyacid precursors

Preferred peroxyacid precursors are amide substituted alkyl peroxyacid precursor compounds, including those of the following general formulae:



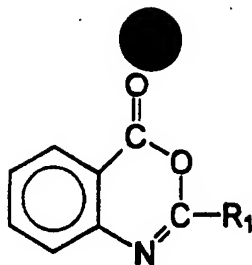


wherein R<sup>1</sup> is an aryl or alkaryl group with from about 1 to about 14 carbon atoms, R<sup>2</sup> is an alkylene, arylene, and alkarylene group containing from about 1 to 14 carbon atoms, and R<sup>5</sup> is H or an alkyl, aryl, or alkaryl group containing 1 to 10 carbon atoms and L can be essentially any leaving group. R<sup>1</sup> preferably contains from about 6 to 12 carbon atoms. R<sup>2</sup> preferably contains from about 4 to 8 carbon atoms. R<sup>1</sup> may be straight chain or branched alkyl, substituted aryl or alkylaryl containing branching, substitution, or both and may be sourced from either synthetic sources or natural sources including for example, tallow fat. Analogous structural variations are permissible for R<sup>2</sup>. R<sup>2</sup> can include alkyl, aryl, wherein said R<sup>2</sup> may also contain halogen, nitrogen, sulphur and other typical substituent groups or organic compounds. R<sup>5</sup> is preferably H or methyl. R<sup>1</sup> and R<sup>5</sup> should not contain more than 18 carbon atoms total. Amide substituted bleach activator compounds of this type are described in EP-A-0170386.

Preferred examples of bleach precursors of this type include amide substituted peroxyacid precursor compounds selected from (6-octanamido-caproyl)oxybenzenesulfonate, (6-decanamido-caproyl)oxybenzene-sulfonate, and the highly preferred (6-nonanamidocaproyl)oxy benzene sulfonate, and mixtures thereof as described in EP-A-0170386.

#### Benzoxazin organic peroxyacid precursors

Also suitable are precursor compounds of the benzoxazin-type, as disclosed for example in EP-A-332,294 and EP-A-482,807, particularly those having the formula:



wherein  $R_1$  is an alkyl, alkaryl, aryl, or arylalkyl containing at least 5 carbon atoms.

### Alkyl percarboxylic acid bleach precursors

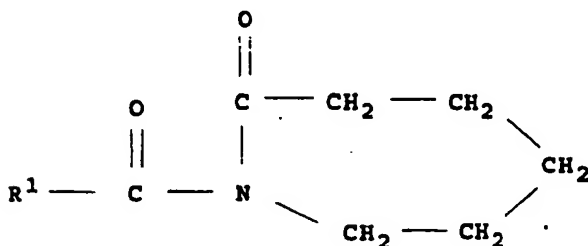
Alkyl percarboxylic acid bleach precursors form percarboxylic acids on perhydrolysis. Preferred alkyl percarboxylic precursor compounds of the imide type include the N-,N,N<sup>1</sup>N<sup>1</sup> tetra acetylated alkylene diamines wherein the alkylene group contains at least 7 carbon atoms.

Other preferred alkyl percarboxylic acid precursors include sodium 3,5,5-tri-methyl hexanoyloxybenzene sulfonate (iso-NOBS) and sodium nonanoyloxybenzene sulfonate (NOBS).

### N-acylated lactam precursors

Still another class of hydrophobic bleach activators are the N-acylated precursor compounds of the lactam class disclosed generally in GB-A-955735. Preferred materials of this class comprise the caprolactams.

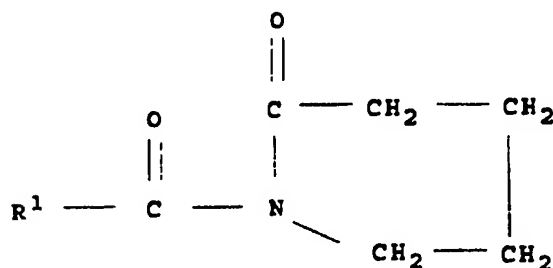
Suitable caprolactam bleach precursors are of the formula:



wherein  $R^1$  is an alkyl, aryl, alkoxyaryl or alkaryl group containing from 6 to 12 carbon atoms. Preferred hydrophobic N-acyl caprolactam bleach precursor materials are selected from benzoyl caprolactam,

octanoyl caprolactam, nonanoyl caprolactam, decanoyl caprolactam, undecenoyl caprolactam, 3,5,5-trimethylhexanoyl caprolactam and mixtures thereof. A most preferred is nonanoyl caprolactam.

**Suitable valero lactams have the formula:**



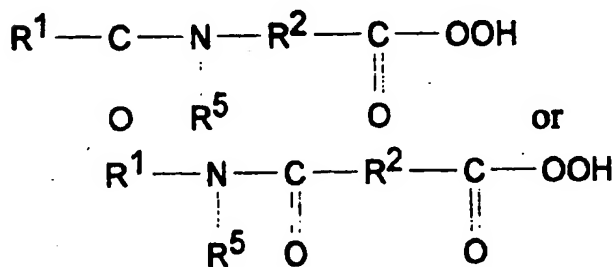
wherein R<sup>1</sup> is an alkyl, aryl, alkoxyaryl or alkaryl group containing from 6 to 12 carbon atoms. More preferably, R<sup>1</sup> is selected from phenyl, heptyl, octyl, nonyl, 2,4,4-trimethylpentyl, decenyl and mixtures thereof.

Mixtures of any of the peroxyacid bleach precursor, herein before described, may also be used.

### Preformed organic peroxyacid

The organic peroxyacid bleaching system may contain, in addition to, or as an alternative to, an organic peroxyacid bleach precursor compound, a preformed hydrophobic organic peroxyacid, typically at a level of from 0.05% to 20% by weight, more preferably from 1% to 10% by weight of the composition.

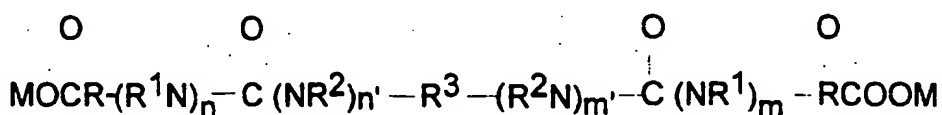
**A preferred class of hydrophobic organic peroxyacid compounds are the amide substituted compounds of the following general formulae:**



wherein  $R^1$  is an aryl or alkaryl group with from about 1 to about 14 carbon atoms,  $R^2$  is an alkylene, arylene, and alkarylene group containing from about 1 to 14 carbon atoms, and  $R^5$  is H or an alkyl, aryl, or alkaryl group containing 1 to 10 carbon atoms.  $R^1$  preferably contains from about 6 to 12 carbon atoms.  $R^2$  preferably contains from about 4 to 8 carbon atoms.  $R^1$  may be straight chain or branched alkyl, substituted aryl or alkylaryl containing branching, substitution, or both and may be sourced from either synthetic sources or natural sources including for example, tallow fat. Analogous structural variations are permissible for  $R^2$ .  $R^2$  can include alkyl, aryl, wherein said  $R^2$  may also contain halogen, nitrogen, sulphur and other typical substituent groups or organic compounds.  $R^5$  is preferably H or methyl.  $R^1$  and  $R^5$  should not contain more than 18 carbon atoms total. Amide substituted bleach activator compounds of this type are described in EP-A-0170386. Suitable examples of this class of agents include (6-octylamino)-6-oxo-caproic acid, (6-nonylamino)-6-oxo-caproic acid, (6-decylamino)-6-oxo-caproic acid, magnesium monoperoxyphthalate hexahydrate, the magnesium salt of metachloro perbenzoic acid, 4-nonylamino-4-oxoperoxybutyric acid and diperoxydodecanedioic acid. Such bleaching agents are disclosed in U.S. 4,483,781, U.S. 4,634,551, EP 0,133,354, U.S. 4,412,934 and EP 0,170,386. A preferred hydrophobic preformed peroxyacid bleach compound for the purpose of the invention is monononylamido peroxycarboxylic acid.

Other suitable organic peroxyacids include diperoxyalkanedioc acids having more than 7 carbon atoms, such as diperoxydodecanedioic acid, diperoxytetradecanedioc acid and diperoxyhexadecanedioc acid.

Other suitable organic peroxyacids include diamino peroxyacids, which are disclosed in WO 95/ 03275, with the following general formula:



wherein:

R is selected from the group consisting of C<sub>1</sub>-C<sub>12</sub> alkylene, C<sub>5</sub>-C<sub>12</sub> cycloalkylene, C<sub>6</sub>-C<sub>12</sub> arylene and radical combinations thereof; R<sup>1</sup> and R<sup>2</sup> are independently selected from the group consisting of H, C<sub>1</sub>-C<sub>16</sub> alkyl and C<sub>6</sub>-C<sub>12</sub> aryl radicals and a radical that can form a C<sub>3</sub>-C<sub>12</sub> ring together with R<sup>3</sup> and both nitrogens; R<sup>3</sup> is selected from the group consisting of C<sub>1</sub>-C<sub>12</sub> alkylene, C<sub>5</sub>-C<sub>12</sub> cycloalkylene and C<sub>6</sub>-C<sub>12</sub> arylene radicals; n and n' each are an integer chosen such that the sum thereof is 1; m and m' each are an integer chosen such that the sum thereof is 1; and M is selected from the group consisting of H, alkali metal, alkaline earth metal, ammonium, alkanolammonium cations and radicals and combinations thereof.

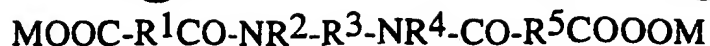
Other suitable organic peroxyacids include the amido peroxyacids which are disclosed in WO 95/ 16673, with the following general structure:



in which X represents hydrogen or a compatible substituent, Ar is an aryl group, R represents (CH<sub>2</sub>)<sub>n</sub> in which n = 2 or 3, and Y and Z each represent independently a substituent selected from hydrogen or an alkyl or aryl or alkaryl group or an aryl group substituted by a compatible substituent provided that at least one of Y and Z is not hydrogen if n = 3. The substituent X on the benzene nucleus is preferably a hydrogen or a meta or para substituent, selected from the group comprising halogen, typically chlorine atom, or some other non-released non-interfering species such as an alkyl group, conveniently up to C<sub>6</sub> for example a methyl, ethyl or propyl group. Alternatively, X can represent a second amido-percarboxylic acid substituent of formula:-



in which R, Y, Z and n are as defined above.



wherein  $R^1$  is selected from the group consisting of  $C_1$ - $C_{12}$  alkylene,  $C_5$ - $C_{12}$  cycloalkylene,  $C_6$ - $C_{12}$  arylene and radical combinations thereof; R

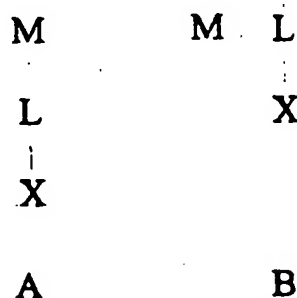
### Cationic polymers

The detergent composition or component thereof can comprise additional polymeric cationic ethoxylated amine compounds with particulate/ clay-soil removal/ anti-redeposition, selected from the group consisting of water-soluble cationic polymers. These polymers comprise a polymer backbone, at least 2M groups and at least one L-X group, wherein M is a cationic group attached to or integral with the backbone; X is a nonionic group selected from the group consisting of H,  $C_1$ - $C_4$  alkyl or hydroxyalkyl ester or ether groups, and mixtures thereof; and L is a hydrophilic chain connecting groups M and X or connecting X to the polymer backbone.

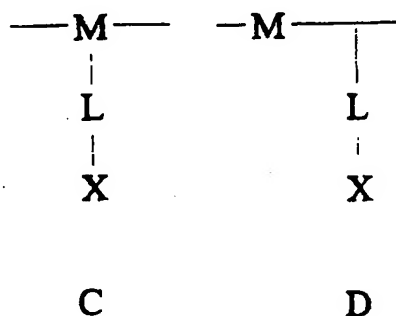
The polymeric cationic ethoxylated amine compounds can be present in detergent compositions at a level of from 0.01 % to 30%, more preferably from 0.1 % to 15%, most preferably from 0.2% to 3% by weight of the detergent composition.

As used herein, the term "polymer backbone" refers to the polymeric moiety to which groups M and L-X are attached or are integral with. Included within this term are oligomer backbones (2 to 4 units), and true polymer backbones (5 or more units).

As used herein, the term "attached to " means that the group is pendent from the polymer backbone, examples of such attachment being represented by the following general structures A and B:

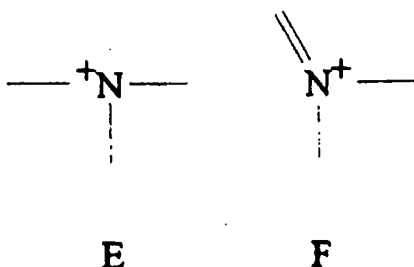


As used herein, the term "integral with" means that the group forms part of the polymer backbone, examples of which are represented by the following general structures C and D:



Any polymer backbone can be used as long as the cationic polymer formed is water-soluble and has clay soil removal/anti-redeposition properties. Suitable polymer backbones can be derived from the polyurethanes, the polyesters, the polyethers, the polyamides, the polyimides and the like; the polyacrylates, the polyacrylamides, the polyvinylethers, the polyethylenes, the polypropylenes and like polyalkylenes, the polystyrenes and like polyalkarylenes, the polyalkyleneamines, the polyalkyleneimines, the polyvinylamines, the polyalylamines, the polydiallylamines, the polyvinylpyridines, the polyaminotriazoles, polyvinyl alcohol, the aminopolyureylenes, and mixtures thereof.

M can be any compatible cationic group which comprises an  $\text{N}^+$  (quarternary), positively charged center. The quarternary positively charged center can be represented by the following general structures E and F:



Particularly preferred M groups are those containing a quaternary center represented by general structure E. The cationic group is preferably positioned close to or integral with the polymer backbone.

The positive charge of the  $N^+$  centres is offset by the appropriate number of counter anions. Suitable counter anions include  $Cl^-$ ,  $Br^-$ ,  $SO_3^{2-}$ ,  $SO_4^{2-}$ ,  $PO_4^{2-}$ ,  $MeOSO_3^-$  and the like. Particularly preferred counter anions are  $Cl^-$  and  $Br^-$ .

X can be a nonionic group selected from hydrogen (H),  $C_1$ - $C_4$  alkyl or hydroxyalkyl ester or ether groups, and mixtures thereof. The preferred ester or ether groups are the acetate ester and methyl ether, respectively; The particularly preferred nonionic groups are H and the methyl ether.

The cationic polymers suitable for use in granular detergent compositions or components thereof in accord with the present inventions normally have a ratio of cationic groups M to nonionic groups X of from about 1:1 to about 1:2. However, for example, by appropriate copolymerization of cationic, nonionic (i.e. containing the group L-X), and mixed cationic/nonionic monomers, the ratio of cationic groups M to nonionic groups X can be varied. The ratio of groups M to groups X can usually range from about 2:1 to about 1:10. In preferred cationic polymers, the ratio is from about 1:1 to about 1:5. The polymers formed from such copolymerization are typically random, i.e. the cationic, nonionic and mixed cationic/nonionic monomers copolymerize in a nonrepeating sequence.

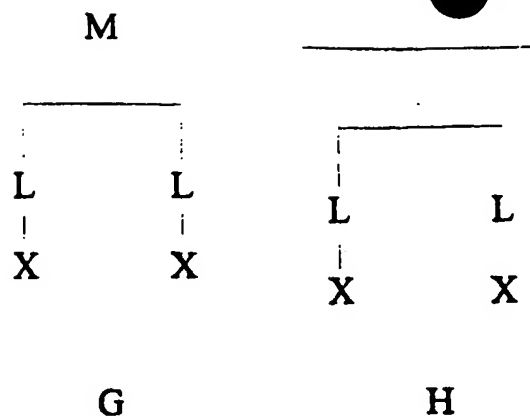


The units which contain groups M and groups L-X can comprise 100% of the cationic polymers of the present invention. However, inclusion of other units (preferably nonionic) in the polymers is also permissible. Examples of other units include acrylamides, vinyl ethers and those containing unquaternized tertiary amine groups ( $M^1$ ) containing an N centre. These other units can comprise from 0% to about 90% of the polymer (from about 10% to 100% of the polymer being units containing M and L-X groups, including  $M^1$ -L-X groups). Normally, these other units comprise from 0% to about 50% of the polymer (from about 50% to 100% of the polymer being units containing M and L-X groups).

The number of groups M and L-X each usually ranges from about 2 to about 200. Typically the number of groups M and L-X are each from about 3 to about 100. Preferably, the number of groups M and L-X are each from about 3 to about 40.

Other than moieties for connecting groups M and X, or for attachment to the polymer backbone, hydrophilic chain L usually consists entirely of the polyoxyalkylene moiety  $-(R'O)_m(CH_2CH_2O)_n-$ . The moieties  $-(R'O)_m-$  and  $-(CH_2CH_2O)_n-$  of the polyoxyalkylene moiety can be mixed together, or preferably form blocks of  $-(R'O)_m-$  and  $-(CH_2CH_2O)_n-$  moieties. R' is preferably  $C_3H_6$  (propylene); m is preferably from 0 to about 5, and most preferably 0; i.e. the polyoxyalkylene moiety consists entirely of the moiety  $-(CH_2CH_2O)_n-$ . The moiety  $-(CH_2CH_2O)_n-$  preferably comprises at least about 85% by weight of the polyoxyalkylene moiety, and most preferably 100% by weight (m is 0). For the moiety  $-(CH_2CH_2O)_n-$ , n is usually from about 3 to about 100. Preferably, n is from about 12 to about 42.

A plurality (2 or more) of moieties -L-X can also be hooked together and attached to group M or to the polymer backbone, examples of which are represented by the following general structures G and H:

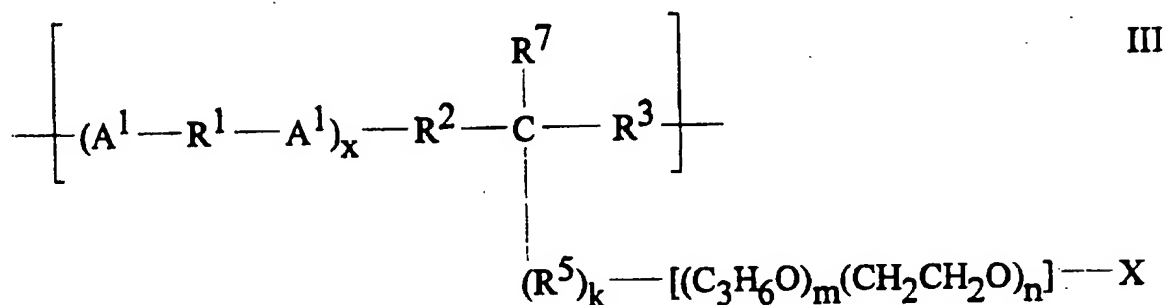
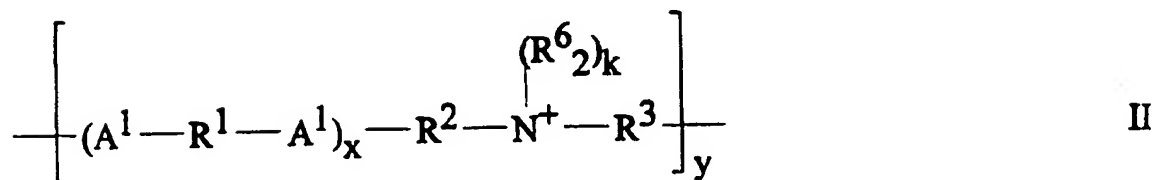
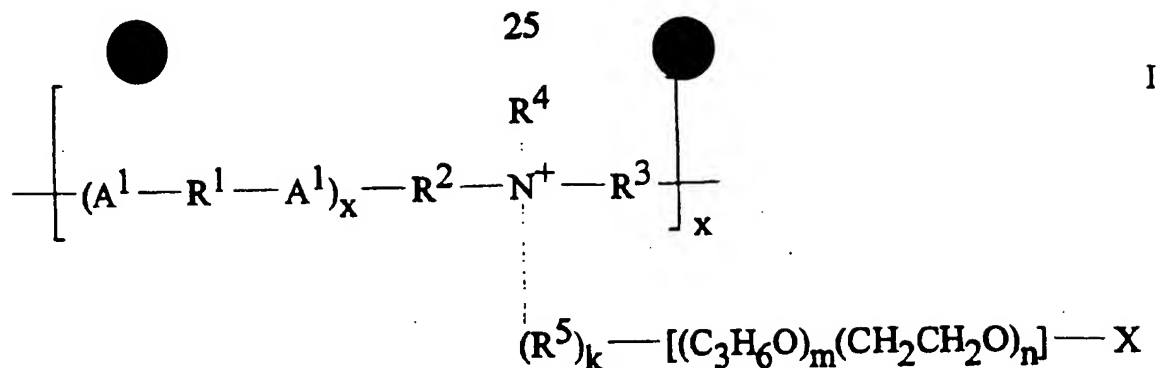


Structures such as G and H can be formed, for example, by reacting glycidol with group M or with the polymer backbone, and ethoxylating the subsequently formed hydroxy groups.

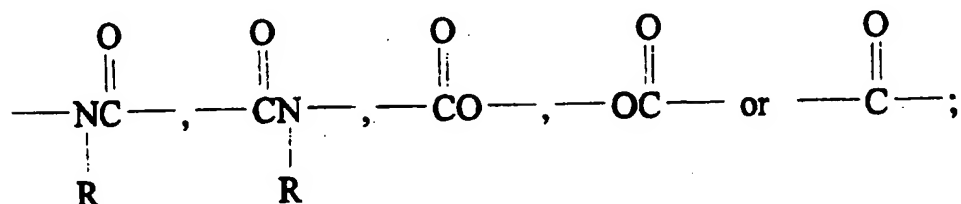
Representative classes of cationic polymers of the present invention are as follows:

A. Polyurethane, Polyester, Polyether, Polyamide or like Polymers.

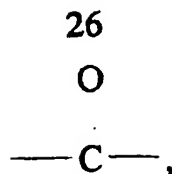
One class of suitable cationic polymers are derived from polyurethanes, polyesters, polyethers, polyamides and the like. These polymers comprise units selected from those having formulas I, II and III:



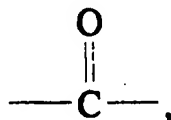
wherein  $A^1$  is



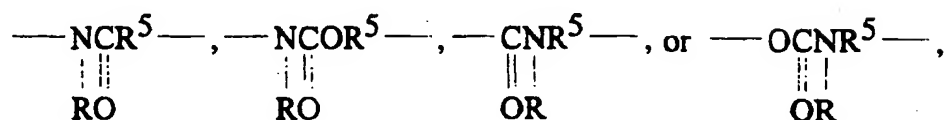
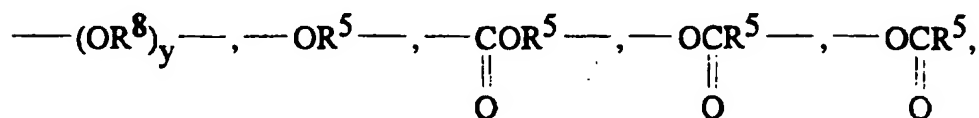
X is 0 or 1; R is H or C<sub>1</sub>-C<sub>4</sub> alkyl or hydroxyalkyl; R<sup>1</sup> is C<sub>2</sub>-C<sub>12</sub> alkylene, hydroxyalkylene, alkenylene, cycloalkylene, arylene or alkarylene, or a C<sub>2</sub>-C<sub>3</sub> oxyalkylene moiety having from 2 to about 20 oxyalkylene units provided that no O-O or O-N bonds are formed with A<sup>1</sup>; when x is 1, R<sup>2</sup> is -R<sup>5</sup>- except when A<sup>1</sup> is



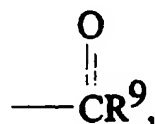
or is  $-(\text{OR}^8)_y-$  or  $-\text{OR}^5-$  provided that no O-O or N-O bonds are formed with  $\text{A}^1$ , and  $\text{R}^3$  is  $-\text{R}^5-$  except when  $\text{A}^1$  is



or is  $-(\text{R}^8\text{O})_y$  or  $-\text{R}^5\text{O}-$  provided that no O-O or O-N bonds are formed with  $\text{A}^1$ ; when  $x$  is 0,  $\text{R}^2$  is



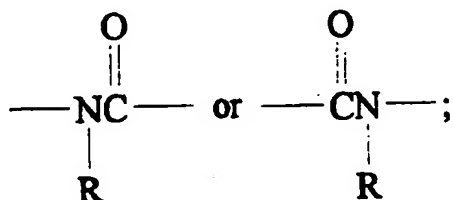
and  $\text{R}^3$  is  $-\text{R}^5-$ ;  $\text{R}^4$  is  $\text{C}_1$ - $\text{C}_4$  alkyl or hydroxyalkyl, or the moiety  $-(\text{R}^5)_k-[(\text{C}_3\text{H}_6\text{O})_m(\text{CH}_2\text{CH}_2\text{O})_n]-\text{X}$ ;  $\text{R}^5$  is  $\text{C}_1$ - $\text{C}_{12}$  alkylene, hydroxyalkylene, alkenylene, arylene, or alkarylene; each  $\text{R}^6$  is  $\text{C}_1$ - $\text{C}_4$  alkyl or hydroxyalkyl, or the moiety  $-(\text{CH}_2)_r-\text{A}^2-(\text{CH}_2)_s-$ , wherein  $\text{A}^2$  is  $-\text{O}-$  or  $-\text{CH}_2-$ ;  $\text{R}^7$  is H or  $\text{R}^4$ ;  $\text{R}^8$  is  $\text{C}_2$ - $\text{C}_3$  alkylene or hydroxyalkylene; X is H,



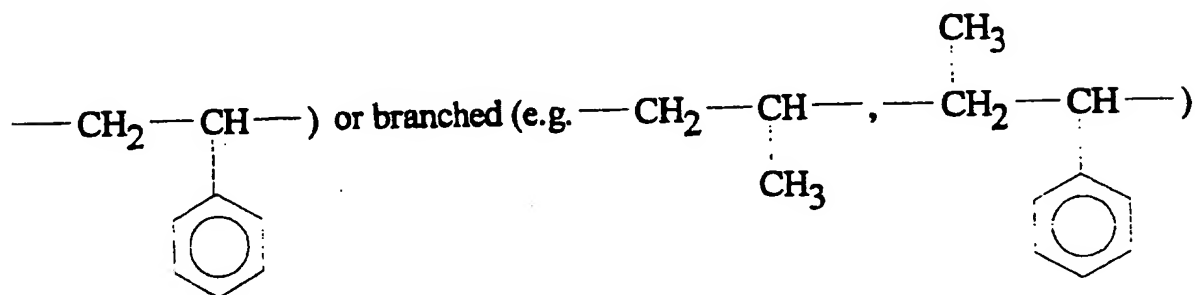
$-\text{R}^9$  or a mixture thereof, wherein  $\text{R}^9$  is  $\text{C}_1$ - $\text{C}_4$  alkyl or hydroxyalkyl;  $k$  is 0 or 1;  $m$  and  $n$  are numbers such that the moiety  $-(\text{CH}_2\text{CH}_2\text{O})_n-$  comprises at least about 85% by weight of the moiety  $[(\text{C}_3\text{H}_6\text{O})_m(\text{CH}_2\text{CH}_2\text{O})_n]-$ ;  $m$  is from 0 to about 5;  $n$  is at least about

3; r is 1 or 2, s is 1 or 2, and r + s is 3 or 4; y is from 2 to about 20; the number of u, v and w are such that there are at least 2 N<sup>+</sup> centers and at least 2 X groups.

In the above formulas, A<sup>1</sup> is preferably



A<sup>2</sup> is preferably -O-; x is preferably 1; and R is preferably H. R<sup>1</sup> can be linear (e.g. -CH<sub>2</sub>-CH<sub>2</sub>-CH<sub>2</sub>-),



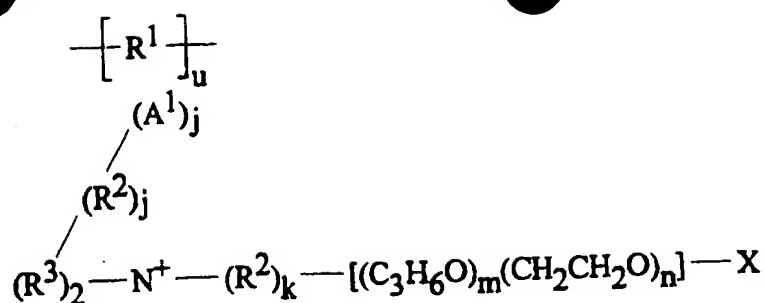
alkylene, hydroxyalkylene, alkenylene, cycloalkylene, alkarylene or oxyalkylene; when R<sup>1</sup> is a C<sub>2</sub>-C<sub>3</sub> oxyalkylene moiety, the number of oxyalkylene units is preferably from about 2 to about 12; R<sup>1</sup> is preferably C<sub>2</sub>-C<sub>6</sub> alkylene or phenylene, and most preferably C<sub>2</sub>-C<sub>6</sub> alkylene (e.g. ethylene, propylene, hexamethylene). R<sup>2</sup> is preferably -OR<sup>5</sup>- or -(OR<sup>8</sup>)<sub>y</sub>-; R<sup>3</sup> is preferably -R<sup>5</sup>O- or -(OR<sup>8</sup>)<sub>y</sub>-; R<sup>4</sup> and R<sup>6</sup> are preferably methyl. Like R<sup>1</sup>, R<sup>5</sup> can be linear or branched, and is preferably C<sub>2</sub>-C<sub>3</sub> alkylene; R<sup>7</sup> is preferably H or C<sub>1</sub>-C<sub>3</sub> alkyl; R<sup>8</sup> is preferably ethylene; R<sup>9</sup> is preferably methyl; X is preferably H or methyl; k is preferably 0; m is preferably 0, r and s are each preferably 2; y is preferably from 2 to about 12.

In the above formulas, n is preferably at least about 6 when the number of N<sup>+</sup> centers and X groups is 2 or 3; n is most preferably at least about 12, with a typical range of about 12 to about 42 for all ranges of u + v + w. For homopolymers (v and w are 0), u is

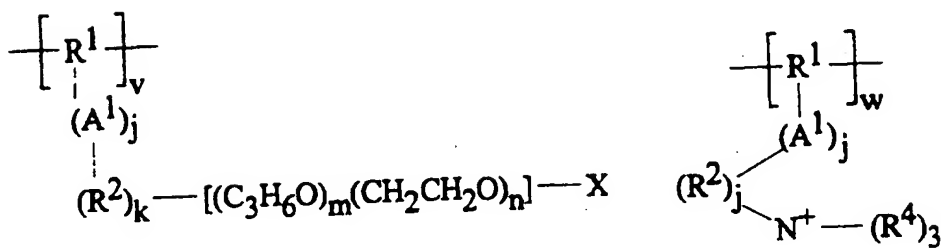
preferably from about 3 to about 20. For random copolymers (u is at least 1 or preferably 0), v and w are each preferably from about 3 to about 40.

**B. Polyacrylate, Polyacrylamide, Polyvinylether or Like Polymers**

Another class of suitable cationic polymers are derived from polyacrylates, polyacrylamides, polyvinylethers and the like. These polymers comprise units selected from those having formulas IV, V and VI.

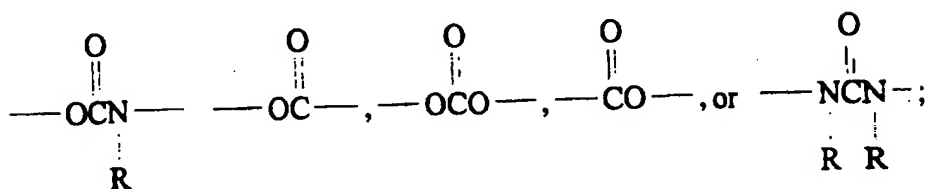
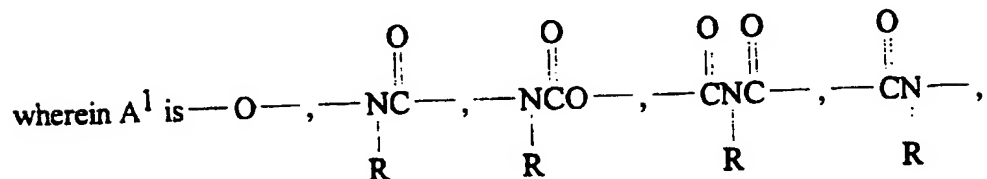


IV



V

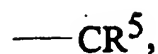
VI



$R$  is H or  $C_1$ - $C_4$  alkyl or hydroxyalkyl;  $R^1$  is substituted  $C_2$ - $C_{12}$  alkylene, hydroxyalkylene, alkenylene, arylene or alkarylene, or  $C_2$ - $C_3$  oxyalkylene; each  $R^2$  is  $C_1$ - $C_{12}$  alkylene, hydroxyalkylene, alkenylene, arylene or alkarylene; each  $R^3$  is  $C_1$ - $C_4$  alkyl or hydroxyalkyl, the moiety  $-(R^2)_k-[(C_3H_6O)_m(CH_2CH_2O)_n]-X$ , or together form the moiety  $-(CH_2)_r-A^2-(CH_2)_s-$ , wherein  $A^2$  is  $-O-$  or  $-CH_2-$ ; each  $R^4$  is  $C_1$ - $C_4$  alkyl or hydroxyalkyl, or two  $R^4$  together form the moiety  $-(CH_2)_r-A^2-(CH_2)_s-$ ;  $X$  is H,

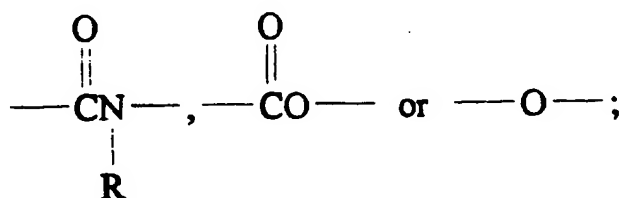
30

O



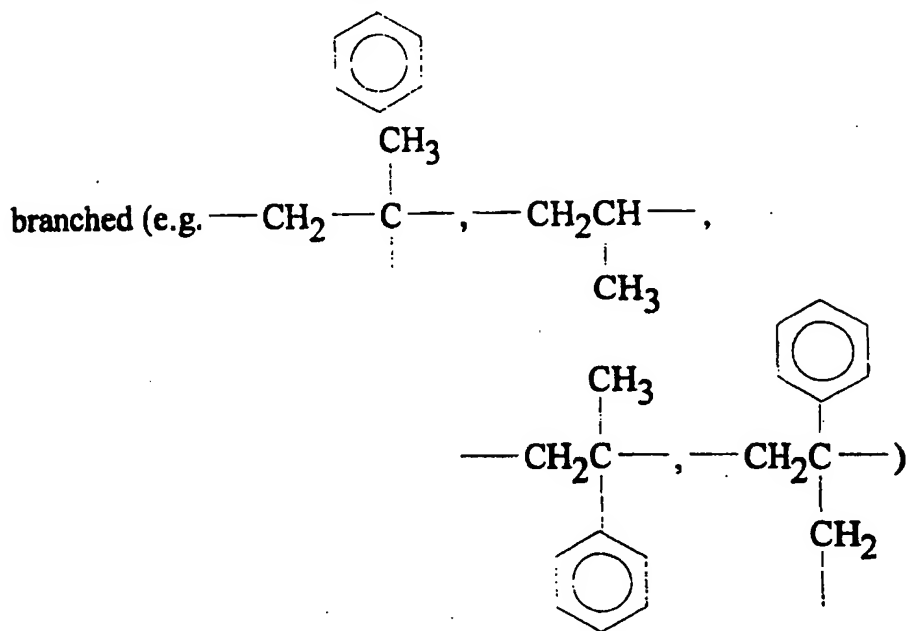
$-R^5$  or mixture thereof, wherein  $R^5$  is  $C_1$ - $C_4$  alkyl or hydroxalkyl;  $j$  is 1 or 0;  $k$  is 1 or 0;  $m$  and  $n$  are numbers such that the moiety  $-(CH_2CH_2O)_n-$  comprises at least about 85% by weight of the moiety  $-[(C_3H_6O)_m(CH_2CH_2O)_n]-$ ;  $m$  is from 0 to about 5;  $n$  is at least about 3;  $r$  is 1 or 2,  $s$  is 1 or 2 and  $r + s$  is 3 or 4; the number of  $u$ ,  $v$  and  $w$  are such that there are at least  $2N+$  centres and at least 2 X groups.

In the above formulas,  $A^1$  is preferably



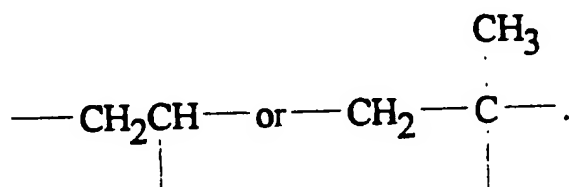
$A^2$  is preferably  $-O-$ ;  $R$  is preferably H.  $R^1$  can be linear

(e.g.  $—CH_2—CH—CH_2—$ ,  $—CH_2CH—$ ) or





substituted alkylene, hydroxyalkylene, alkenylene, alkarylene or oxyalkylene;  $R^1$  is preferably substituted  $C_2-C_6$  alkylene or substituted  $C_2-C_3$  oxyalkylene, and most preferably

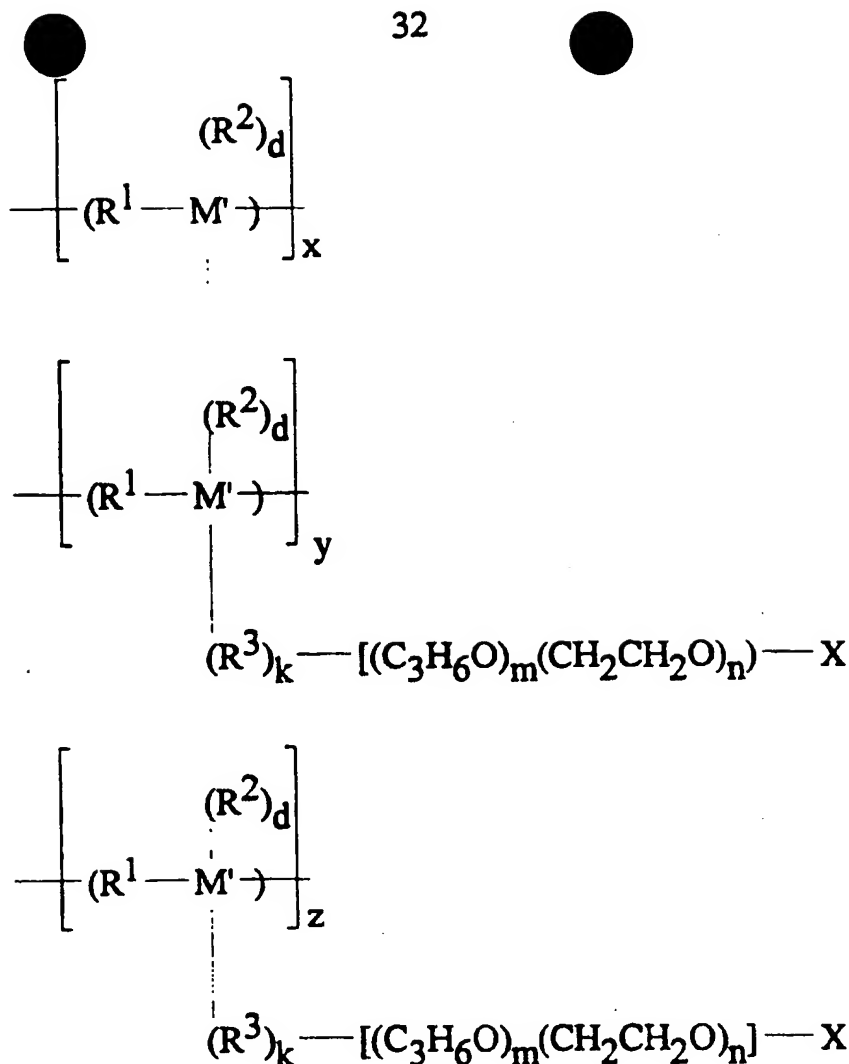


Each  $R^2$  is preferably  $C_2-C_3$  alkylene, each  $R^3$  and  $R^4$  are preferably methyl;  $R^5$  is preferably methyl;  $X$  is preferably H or methyl;  $j$  is preferably 1;  $k$  is preferably 0;  $m$  is preferably 0;  $r$  and  $s$  are each preferably 2.

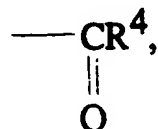
In the above formulas,  $n$ ,  $u$ ,  $v$  and  $w$  can be varied according to the  $n$ ,  $u$ ,  $v$  and  $w$  for the polyurethane and like polymers.

C. Polyalkyleneamine, Polyalkyleneimine or like polymers.

Another class of suitable cationic polymers are derived from polyalkyleneamines, polyalkyleneimines and the like. These polymers comprise units selected from those having formulas VII and VIII and IX.



wherein  $R^1$  is  $C_2$ - $C_{12}$  alkylene, hydroxyalkylene, alkenylene, cycloalkylene, arylene or alkarylene, or a  $C_2$ - $C_3$  oxyalkylene moiety having from 2 to about 20 oxyalkylene units provided that no O-N bonds are formed; each  $R^2$  is  $C_1$ - $C_4$  alkyl or hydroxyalkyl, or the moiety  $-(R^3)_k-[(C_3H_6O)_m(CH_2CH_2O)_n]-X$ ;  $R^3$  is  $C_1$ - $C_{12}$  alkylene, hydroxyalkylene, alkenylene, arylene or alkarylene;  $M'$  is an  $N^+$  or  $N$  centre;  $X$  is H,



$-R^4$  or mixture thereof, wherein  $R^4$  is  $C_1$ - $C_4$  alkyl or hydroxyalkyl;  $d$  is 1 when  $M'$  is  $N^+$  and is 0 when  $M'$  is  $N$ ;  $e$  is 2 when  $M'$  is  $N^+$

and is 1 when M' is N; k is 1 or 0; m and n are numbers such that the moiety

$-(\text{CH}_2\text{CH}_2\text{O})_n-$  comprises at least about 85% by weight of the moiety  $-[(\text{C}_3\text{H}_6\text{O})_m(\text{CH}_2\text{CH}_2\text{O})_n]-$ ; m is from 0 to about 5; n is at least about 3; the number of x, y and z are such that there are at least  $2M'$  groups, at least  $2N+$  centres and at least 2 X groups.

In the above formulas,  $R^1$  can be varied like  $R^1$  of the polyurethane and like polymers; each  $R^2$  is preferably methyl or the moiety  $-(R^3)_k-[(\text{C}_3\text{H}_6\text{O})_m(\text{CH}_2\text{CH}_2\text{O})_n]-X$ ;  $R^3$  is preferably  $\text{C}_2$ - $\text{C}_3$  alkylene;  $R^4$  is preferably methyl; X is preferably H; k is preferably 0; m is preferably 0.

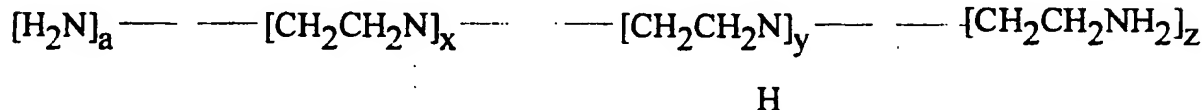
In the above formulas, n is preferably at least about 6 when the number of M' and X groups is 2 or 3; n is most preferably at least about 12, with a typical range of from about 12 to about 42 for all ranges of  $x + y + z$ . Typically,  $x + y + z$  is from 2 to about 40 and preferably from 2 to about 20. For short chain length polymers,  $x + y + z$  can range from 2 to 9 with from 2 to 9  $N+$  centres and from 2 to 11 X groups. For long chain length polymers,  $x + y + z$  is at least 10, with a preferred range of from 10 to about 42. For the short and long chain length polymers, the M' groups are typically a mixture of from about 50 to 100%  $N+$  centres and from 0 to about 50% N centres.

Preferred cationic polymers within this class are derived from the  $\text{C}_2$ - $\text{C}_3$  polyalkyleneamines ( $x + y + z$  is from 2 to 9) and polyalkyleneimines ( $x + y + z$  is at least 10, preferably from 10 to about 42). Particularly preferred cationic polyalkyleneamines and polyalkyleneimines are the cationic polyethyleneamines (PEA's) and polyethyleneimines (PEI's). These preferred cationic polymers comprise units having the general formula:

$(R^2)_d$  $(R^2)_d$  $[M']_a$ —— $[CH_2-CH_2M']_x$ — $[(CH_2CH_2O)_n-X]_2$  $(R^2)_d$  $(R^2)_d$ — $[CH_2CH_2M']_y$ —— $[CH_2CH_2M']_z$  $(CH_2CH_2O)_n-X$  $[(CH_2CH_2O)_n-X]_2$ 

wherein  $R^2$  (preferably methyl),  $M'$ ,  $X$ ,  $d$ ,  $x$ ,  $y$ ,  $z$  and  $n$  are defined as before;  $a$  is 1 or 0.

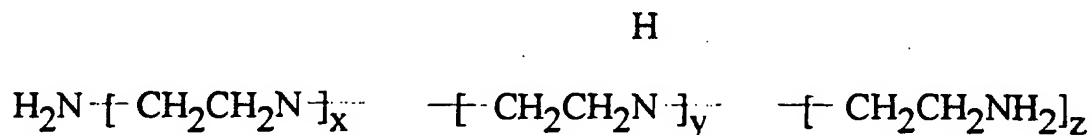
Prior to ethoxylation, the PEAs used in preparing cationic polymers of the present invention have the following general formula:



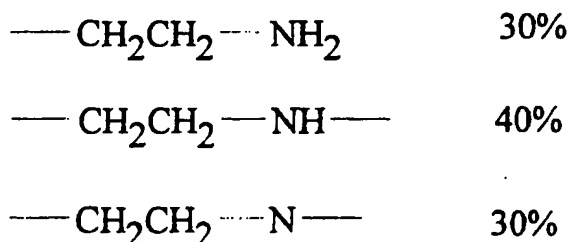
wherein  $x + y + z$  is from 2 to 9, and  $a$  is 0 or 1 (molecular weight of from about 100 to about 400). Each hydrogen atom attached to each nitrogen atom represents an active site for subsequent ethoxylation. For preferred PEAs,  $x + y + z$  is from about 3 to about 7 (molecular weight is from about 140 to about 310). These PEA's can be obtained by reactions involving ammonia and ethylene dichloride, followed by fractional distillation. The common PEA's obtained are triethylenetetramine (TETA) and tetraethylenepentamine (TEPA). Above the pentamines, i.e., the hexamines, heptamines, octamines and possibly nonamines, the cogenerically derived mixture does not appear to separate by distillation and can include other materials such as cyclic amines and particularly piperazines. There can also be present cyclic amines with side chains in which nitrogen atoms appear. See US Pat. No. 2,792,372 to Dickson, issues May 14, 1957, which describes the preparation of PEAs.

The minimum degree of ethoxylation required for preferred clay soil removal/anti-redeposition performance can vary depending upon the number of units in the PEA. Where  $y + z$  is 2 or 3,  $n$  is preferably at least about 6. Where  $y + z$  is from 4 to 9, suitable benefits are achieved when  $n$  is at least about 3. For preferred cationic PEAs,  $n$  is at least about 12, with a typical range of about 12 to about 42.

The PEIs used in preparing the polymers of the present invention have a molecular weight of at least about 440 prior to ethoxylation, which represents at least about 10 units. Preferred PEIs used in preparing these polymers have a molecular weight of from about 600 to about 1800. The polymer backbone of these PEIs can be represented by the general formula:



wherein the sum of  $x$ ,  $y$ , and  $z$  represents a number of sufficient magnitude to yield a polymer having the molecular weights previously specified. Although linear polymer backbones are possible, branch chains can also occur. The relative proportions of primary, secondary and tertiary amine groups present in the polymer can vary, depending on the manner of preparation. The distribution of amine groups is typically as follows:



Each hydrogen atom attached to each nitrogen atom of the PEI represents an active site for subsequent ethoxylation. These PEIs can

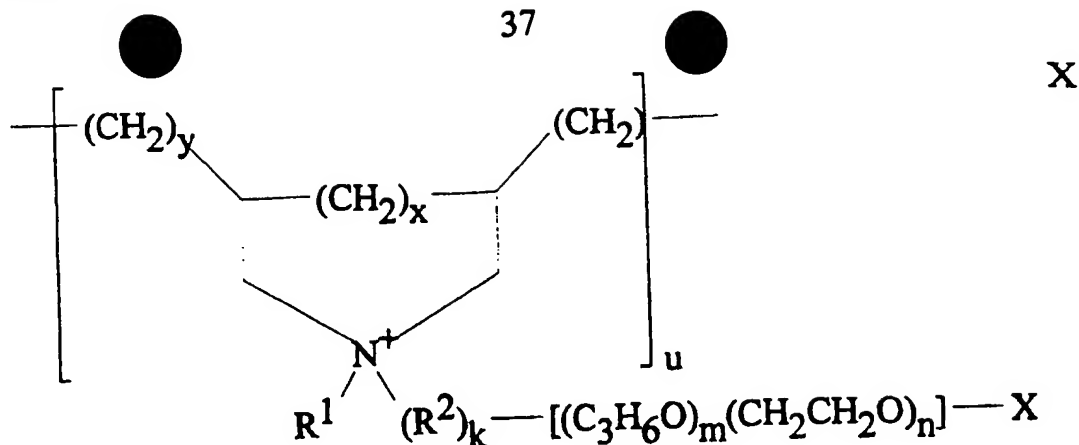
be prepared, for example, by polymerizing ethyleneimine in the presence of a catalyst such as carbon dioxide, sodium bisulfite, sulfuric acid, hydrogen peroxide, hydrochloric acid, acetic acid, etc. Specific methods for preparing PEIs are disclosed in US Pat. No. 2,182,306 to Ulrich et al., issued Dec. 5, 1939; US Pat No. 3,033,746 to Mayle et al., issued May 8, 1962; US Pat. No. 2,208,095 to Esselmann et al., issued July 16, 1940; US Pat. No. 2,806,839 to Crowther, issued Sept. 17, 1957; and US Pat. No. 2,533,696 to Wilson, issued May 21, 1951 (all herein incorporated by reference).

As defined in the preceding formulas,  $n$  is at least about 3 for the cationic PEIs. However, it should be noted that the minimum degree of ethoxylation required for suitable clay soil removal/anti-redeposition performance can increase as the molecular weight of the PEI increases, especially much beyond about 1800. Also, the degree of ethoxylation for preferred polymers increases as the molecular weight of the PEI increases. For PEIs having a molecular weight of at least about 600,  $n$  is preferably at least about 12, with a typical range of from about 12 to about 42. For PEIs having a molecular weight of at least 1800,  $n$  is preferably at least about 24, with a typical range of from about 24 to about 42.

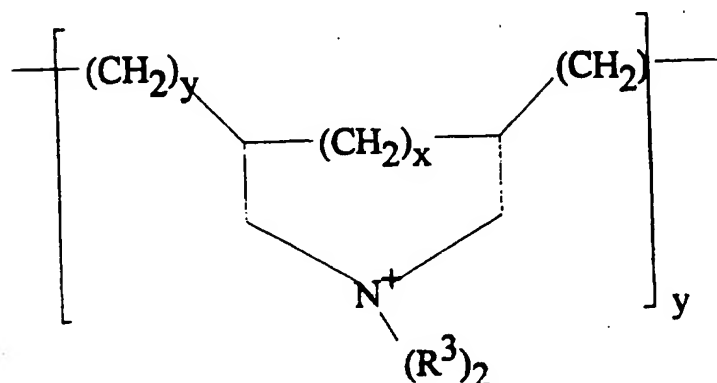
#### D. Diallylamine Polymers

Another class of suitable cationic polymers are those derived from the diallylamines. These polymers comprise units selected from those having formulas X and XI:

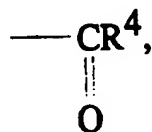
37



XI



wherein  $\text{R}^1$  is  $\text{C}_1\text{-C}_4$  alkyl or hydroxyalkyl, or the moiety  $\text{---}(\text{R}^2)_k\text{---}[(\text{C}_3\text{H}_6\text{O})_m(\text{CH}_2\text{CH}_2\text{O})_n]\text{---X}$ ;  $\text{R}^2$  is  $\text{C}_1\text{-C}_{12}$  alkylene, hydroxyalkylene, alkylene, arylene or alkarylene; each  $\text{R}^3$  is  $\text{C}_1\text{-C}_4$  alkyl or hydroxyalkyl, or together form the moiety  $\text{---}(\text{CH}_2)_r\text{---A---}(\text{CH}_2)_s\text{---}$ , wherein A is  $\text{---O---}$  or  $\text{---CH}_2\text{---}$ ; X is H,



$\text{---R}^4$  or mixture thereof, wherein  $\text{R}^4$  is  $\text{C}_1\text{-C}_4$  alkyl or hydroxyalkyl; k is 1 or 0; m and n are numbers such that the moiety  $\text{---}(\text{CH}_2\text{CH}_2\text{O})_n\text{---}$  comprises at least about 85% by weight of the moiety  $\text{---}[(\text{C}_3\text{H}_6\text{O})_m(\text{CH}_2\text{CH}_2\text{O})_n]\text{---}$ ; m is from 0 to about 5; n is at least about 3; r is 1 or 2, s is 1 or 2, and  $r + s$  is 3 or 4; x is 1 or 0; y is 1 when x is 0 and 0 when x is 1; the number of u and v are such that there are at least  $2N +$  centres and at least 2 X groups.

In the above formulas, A is preferably -O-;  $R^1$  is preferably methyl; each  $R^2$  is preferably  $C_2$ - $C_3$  alkylene; each  $R^3$  is preferably methyl;  $R^4$  is preferably methyl; X is preferably H; k is preferably 0; m is preferably 0; r and s are each preferably 2.

In the above formulas, n is preferably at least about 6 when the number of  $N^+$  centres and X groups are each 2 or 3, n is preferably at least 12, with a typical range of from about 12 to about 42 for all range of  $u + v$ . Typically, v is 0, and u is from 2 to about 40, and preferably from 2 to about 20.

#### Additional detergent components

The detergent compositions or components thereof in accord with the invention may also contain additional detergent components. The precise nature of these additional components, and levels of incorporation thereof will depend on the physical form of the composition or component, and the precise nature of the washing operation for which it is to be used.

The compositions or components thereof, of the invention preferably contain one or more additional detergent components selected from additional surfactants, additional bleaches, bleach catalysts, alkalinity systems, builders, organic polymeric compounds, enzymes, suds suppressors, lime soap dispersants, additional soil suspension and anti-redeposition agents soil releasing agents, perfumes and corrosion inhibitors.

#### Additional surfactant

The detergent compositions or components thereof in accord with the invention preferably contain an additional surfactant selected from anionic, nonionic, cationic, ampholytic, amphoteric and zwitterionic surfactants and mixtures thereof.



A typical listing of anionic, nonionic, ampholytic, and zwitterionic classes, and species of these surfactants, is given in U.S.P. 3,929,678 issued to Laughlin and Heuring on December 30, 1975. Further examples are given in "Surface Active Agents and Detergents" (Vol. I and II by Schwartz, Perry and Berch). A list of suitable cationic surfactants is given in U.S.P. 4,259,217 issued to Murphy on March 31, 1981.

Where present, ampholytic, amphoteric and zwitterionic surfactants are generally used in combination with one or more anionic and/or nonionic surfactants.

#### Anionic surfactant

The detergent compositions or compositions thereof in accord with the present invention preferably comprise an additional anionic surfactant. Essentially any anionic surfactants useful for deterative purposes can be comprised in the detergent composition. These can include salts (including, for example, sodium, potassium, ammonium, and substituted ammonium salts such as mono-, di- and triethanolamine salts) of the anionic sulfate, sulfonate, carboxylate and sarcosinate surfactants. Anionic sulfate surfactants are preferred.

Other anionic surfactants include the isethionates such as the acyl isethionates, N-acyl taurates, fatty acid amides of methyl tauride, alkyl succinates and sulfosuccinates, monoesters of sulfosuccinate (especially saturated and unsaturated  $C_{12}$ - $C_{18}$  monoesters) diesters of sulfosuccinate (especially saturated and unsaturated  $C_6$ - $C_{14}$  diesters), N-acyl sarcosinates. Resin acids and hydrogenated resin acids are also suitable, such as rosin, hydrogenated rosin, and resin acids and hydrogenated resin acids present in or derived from tallow oil.

#### Anionic sulfate surfactant

Anionic sulfate surfactants suitable for use herein include the linear and branched primary and secondary alkyl sulfates, alkyl ethoxysulfates, fatty oleoyl glycerol sulfates, alkyl phenol ethylene

NOT FURNISHED AT TIME OF PUBLICATION

soaps ('alkyl carboxyls'), especially certain secondary soaps as described herein.

Suitable alkyl ethoxy carboxylates include those with the formula  $RO(CH_2CH_2O)_x CH_2COO-M^+$  wherein R is a C<sub>6</sub> to C<sub>18</sub> alkyl group, x ranges from 0 to 10, and the ethoxylate distribution is such that, on a weight basis, the amount of material where x is 0 is less than 20 % and M is a cation. Suitable alkyl polyethoxy polycarboxylate surfactants include those having the formula  $RO-(CHR_1-CHR_2-O)-R_3$  wherein R is a C<sub>6</sub> to C<sub>18</sub> alkyl group, x is from 1 to 25, R<sub>1</sub> and R<sub>2</sub> are selected from the group consisting of hydrogen, methyl acid radical, succinic acid radical, hydroxysuccinic acid radical, and mixtures thereof, and R<sub>3</sub> is selected from the group consisting of hydrogen, substituted or unsubstituted hydrocarbon having between 1 and 8 carbon atoms, and mixtures thereof.

Suitable soap surfactants include the secondary soap surfactants which contain a carboxyl unit connected to a secondary carbon. Preferred secondary soap surfactants for use herein are water-soluble members selected from the group consisting of the water-soluble salts of 2-methyl-1-undecanoic acid, 2-ethyl-1-decanoic acid, 2-propyl-1-nonanoic acid, 2-butyl-1-octanoic acid and 2-pentyl-1-heptanoic acid. Certain soaps may also be included as suds suppressors.

#### Alkali metal sarcosinate surfactant

Other suitable anionic surfactants are the alkali metal sarcosinates of formula  $R-CON(R^1)CH_2COOM$ , wherein R is a C<sub>5</sub>-C<sub>17</sub> linear or branched alkyl or alkenyl group, R<sup>1</sup> is a C<sub>1</sub>-C<sub>4</sub> alkyl group and M is an alkali metal ion. Preferred examples are the myristyl and oleoyl methyl sarcosinates in the form of their sodium salts.

#### Alkoxyated nonionic surfactant

Essentially any alkoxyated nonionic surfactants are suitable herein. The ethoxylated and propoxylated nonionic surfactants are preferred.

Preferred alkoxyated surfactants can be selected from the classes of the nonionic condensates of alkyl phenols, nonionic ethoxylated alcohols, nonionic ethoxylated/propoxylated fatty alcohols, nonionic ethoxylate/propoxylate condensates with propylene glycol, and the nonionic ethoxylate condensation products with propylene oxide/ethylene diamine adducts.

#### Nonionic alkoxyated alcohol surfactant

The condensation products of aliphatic alcohols with from 1 to 25 moles of alkylene oxide, particularly ethylene oxide and/or propylene oxide, are suitable for use herein. The alkyl chain of the aliphatic alcohol can either be straight or branched, primary or secondary, and generally contains from 6 to 22 carbon atoms. Particularly preferred are the condensation products of alcohols having an alkyl group containing from 8 to 20 carbon atoms with from 2 to 10 moles of ethylene oxide per mole of alcohol.

#### Nonionic polyhydroxy fatty acid amide surfactant

Polyhydroxy fatty acid amides suitable for use herein are those having the structural formula  $R^2CONR^1Z$  wherein :  $R^1$  is H,  $C_1$ - $C_4$  hydrocarbyl, 2-hydroxy ethyl, 2-hydroxy propyl, ethoxy, propoxy, or a mixture thereof, preferable  $C_1$ - $C_4$  alkyl, more preferably  $C_1$  or  $C_2$  alkyl, most preferably  $C_1$  alkyl (i.e., methyl); and  $R^2$  is a  $C_5$ - $C_{31}$  hydrocarbyl, preferably straight-chain  $C_5$ - $C_{19}$  alkyl or alkenyl, more preferably straight-chain  $C_9$ - $C_{17}$  alkyl or alkenyl, most preferably straight-chain  $C_{11}$ - $C_{17}$  alkyl or alkenyl, or mixture thereof; and Z is a polyhydroxyhydrocarbyl having a linear hydrocarbyl chain with at least 3 hydroxyls directly connected to the chain, or an alkoxyated derivative (preferably ethoxylated or propoxylated) thereof. Z preferably will be derived from a reducing sugar in a reductive amination reaction; more preferably Z is a glycityl.

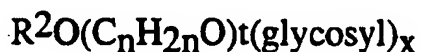
#### Nonionic fatty acid amide surfactant

Suitable fatty acid amide surfactants include those having the formula:  $R^6\text{CON}(R^7)_2$  wherein  $R^6$  is an alkyl group containing from 7 to 21, preferably from 9 to 17 carbon atoms and each  $R^7$  is selected from the group consisting of hydrogen,  $C_1$ - $C_4$  alkyl,  $C_1$ - $C_4$  hydroxyalkyl, and  $-(C_2H_4O)_xH$ , where x is in the range of from 1 to 3.

#### Nonionic alkylpolysaccharide surfactant

Suitable alkylpolysaccharides for use herein are disclosed in U.S. Patent 4,565,647, Llenado, issued January 21, 1986, having a hydrophobic group containing from 6 to 30 carbon atoms and a polysaccharide, e.g., a polyglycoside, hydrophilic group containing from 1.3 to 10 saccharide units.

Preferred alkylpolyglycosides have the formula



wherein  $R^2$  is selected from the group consisting of alkyl, alkylphenyl, hydroxyalkyl, hydroxyalkylphenyl, and mixtures thereof in which the alkyl groups contain from 10 to 18 carbon atoms; n is 2 or 3; t is from 0 to 10, and x is from 1.3 to 8. The glycosyl is preferably derived from glucose.

#### Amphoteric surfactant

Suitable amphoteric surfactants for use herein include the amine oxide surfactants and the alkyl amphocarboxylic acids.

Suitable amine oxides include those compounds having the formula  $R^3(OR^4)_xN^+(R^5)_2$  wherein  $R^3$  is selected from an alkyl, hydroxyalkyl, acylamidopropoyl and alkyl phenyl group, or mixtures thereof, containing from 8 to 26 carbon atoms;  $R^4$  is an alkylene or hydroxyalkylene group containing from 2 to 3 carbon atoms, or mixtures thereof; x is from 0 to 5, preferably from 0 to 3; and each  $R^5$  is an alkyl or hydroxyalkyl group containing from 1 to 3, or a polyethylene oxide group containing from 1 to 3 ethylene oxide

groups. Preferred are C<sub>10</sub>-C<sub>18</sub> alkyl dimethylamine oxide, and C<sub>10</sub>-18 acylamido alkyl dimethylamine oxide.

A suitable example of an alkyl aphodicarboxylic acid is Miranol(TM) C2M Conc. manufactured by Miranol, Inc., Dayton, NJ.

#### Zwitterionic surfactant

Zwitterionic surfactants can also be incorporated into the detergent compositions or components thereof in accord with the invention. These surfactants can be broadly described as derivatives of secondary and tertiary amines, derivatives of heterocyclic secondary and tertiary amines, or derivatives of quaternary ammonium, quaternary phosphonium or tertiary sulfonium compounds. Betaine and sultaine surfactants are exemplary zwitterionic surfactants for use herein.

Suitable betaines are those compounds having the formula  $R(R')_2N^+R^2COO^-$  wherein R is a C<sub>6</sub>-C<sub>18</sub> hydrocarbyl group, each R<sup>1</sup> is typically C<sub>1</sub>-C<sub>3</sub> alkyl, and R<sup>2</sup> is a C<sub>1</sub>-C<sub>5</sub> hydrocarbyl group. Preferred betaines are C<sub>12</sub>-18 dimethyl-ammonio hexanoate and the C<sub>10</sub>-18 acylamidopropane (or ethane) dimethyl (or diethyl) betaines. Complex betaine surfactants are also suitable for use herein.

#### Cationic surfactants

Suitable cationic surfactants to be used in the detergent compositions or components thereof herein include the quaternary ammonium surfactants selected from mono C<sub>6</sub>-C<sub>16</sub>, preferably C<sub>6</sub>-C<sub>10</sub> N-alkyl or alkenyl ammonium surfactants wherein the remaining N positions are substituted by methyl, hydroxyethyl or hydroxypropyl groups.

Another suitable group of cationic surfactants which can be used in the detergent compositions or components thereof herein are cationic ester surfactants.

The cationic ester surfactant is a, preferably water dispersible, compound having surfactant properties comprising at least one ester (i.e. -COO-) linkage and at least one cationically charged group.

Suitable cationic ester surfactants, including choline ester surfactants, have for example been disclosed in US Patents No.s 4228042, 4239660 and 4260529.

In one preferred aspect the ester linkage and cationically charged group are separated from each other in the surfactant molecule by a spacer group consisting of a chain comprising at least three atoms (i.e. of three atoms chain length), preferably from three to eight atoms, more preferably from three to five atoms, most preferably three atoms. The atoms forming the spacer group chain are selected from the group consisting of carbon, nitrogen and oxygen atoms and any mixtures thereof, with the proviso that any nitrogen or oxygen atom in said chain connects only with carbon atoms in the chain. Thus spacer groups having, for example, -O-O- (i.e. peroxide), -N-N-, and -N-O- linkages are excluded, whilst spacer groups having, for example -CH<sub>2</sub>-O-CH<sub>2</sub>- and -CH<sub>2</sub>-NH-CH<sub>2</sub>- linkages are included. In a preferred aspect the spacer group chain comprises only carbon atoms, most preferably the chain is a hydrocarbyl chain.

#### Water-soluble builder compound

The detergent compositions or components thereof in accord with the present invention preferably contain a water-soluble builder compound, typically present in detergent compositions at a level of from 1 % to 80 % by weight, preferably from 10 % to 70 % by weight, most preferably from 20 % to 60 % by weight of the composition.

Suitable water-soluble builder compounds include the water soluble monomeric polycarboxylates, or their acid forms, homo or copolymeric polycarboxylic acids or their salts in which the polycarboxylic acid comprises at least two carboxylic radicals separated from each other by not more than two carbon atoms, borates, phosphates, and mixtures of any of the foregoing.

The carboxylate or polycarboxylate builder can be monomeric or oligomeric in type although monomeric polycarboxylates are generally preferred for reasons of cost and performance.

Suitable carboxylates containing one carboxy group include the water soluble salts of lactic acid, glycolic acid and ether derivatives thereof. Polycarboxylates containing two carboxy groups include the water-soluble salts of succinic acid, malonic acid, (ethylenedioxy) diacetic acid, maleic acid, diglycolic acid, tartaric acid, tartronic acid and fumaric acid, as well as the ether carboxylates and the sulfinyl carboxylates. Polycarboxylates containing three carboxy groups include, in particular, water-soluble citrates, aconitrates and citraconates as well as succinate derivatives such as the carboxymethyloxysuccinates described in British Patent No. 1,379,241, lactoxysuccinates described in British Patent No. 1,389,732, and aminosuccinates described in Netherlands Application 7205873, and the oxypolycarboxylate materials such as 2-oxa-1,1,3-propane tricarboxylates described in British Patent No. 1,387,447.

Polycarboxylates containing four carboxy groups include oxydisuccinates disclosed in British Patent No. 1,261,829, 1,1,2,2-ethane tetracarboxylates, 1,1,3,3-propane tetracarboxylates and 1,1,2,3-propane tetracarboxylates. Polycarboxylates containing sulfo substituents include the sulfosuccinate derivatives disclosed in British Patent Nos. 1,398,421 and 1,398,422 and in U.S. Patent No. 3,936,448, and the sulfonated pyrolysed citrates described in British Patent No. 1,439,000. Preferred polycarboxylates are hydroxycarboxylates containing up to three carboxy groups per molecule, more particularly citrates.

The parent acids of the monomeric or oligomeric polycarboxylate chelating agents or mixtures thereof with their salts, e.g. citric acid or citrate/citric acid mixtures are also contemplated as useful builder components.



Borate builders, as well as builders containing borate-forming materials that can produce borate under detergent storage or wash conditions are useful water-soluble builders herein.

Suitable examples of water-soluble phosphate builders are the alkali metal tripolyphosphates, sodium, potassium and ammonium pyrophosphate, sodium and potassium and ammonium pyrophosphate, sodium and potassium orthophosphate, sodium polymeta/phosphate in which the degree of polymerization ranges from about 6 to 21, and salts of phytic acid.

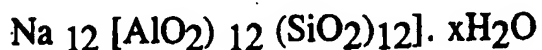
#### Partially soluble or insoluble builder compound

The detergent compositions or compositions thereof in accord with the present invention may contain a partially soluble or insoluble builder compound, typically present in detergent compositions at a level of from 1% to 80% by weight, preferably from 10% to 70% by weight, most preferably from 20% to 60% weight of the composition.

Examples of largely water insoluble builders include the sodium aluminosilicates.

Suitable aluminosilicate zeolites have the unit cell formula  $\text{Na}_z[(\text{AlO}_2)_z(\text{SiO}_2)_y] \cdot x\text{H}_2\text{O}$  wherein  $z$  and  $y$  are at least 6; the molar ratio of  $z$  to  $y$  is from 1.0 to 0.5 and  $x$  is at least 5, preferably from 7.5 to 276, more preferably from 10 to 264. The aluminosilicate material are in hydrated form and are preferably crystalline, containing from 10% to 28%, more preferably from 18% to 22% water in bound form.

The aluminosilicate zeolites can be naturally occurring materials, but are preferably synthetically derived. Synthetic crystalline aluminosilicate ion exchange materials are available under the designations Zeolite A, Zeolite B, Zeolite P, Zeolite X, Zeolite HS and mixtures thereof. Zeolite A has the formula



wherein x is from 20 to 30, especially 27. Zeolite X has the formula  $\text{Na}_{86} [(\text{AlO}_2)_{86}(\text{SiO}_2)_{106}] \cdot 276 \text{H}_2\text{O}$ .

Another preferred aluminosilicate zeolite is zeolite MAP builder. The zeolite MAP can be present at a level of from 1% to 80%, more preferably from 15% to 40% by weight of the compositions.

Zeolite MAP is described in EP 384070A (Unilever). It is defined as an alkali metal alumino-silicate of the zeolite P type having a silicon to aluminium ratio not greater than 1.33, preferably within the range from 0.9 to 1.33 and more preferably within the range of from 0.9 to 1.2.

Of particular interest is zeolite MAP having a silicon to aluminium ratio not greater than 1.15 and, more particularly, not greater than 1.07.

In a preferred aspect the zeolite MAP detergent builder has a particle size, expressed as a  $d_{50}$  value of from 1.0 to 10.0 micrometres, more preferably from 2.0 to 7.0 micrometres, most preferably from 2.5 to 5.0 micrometres.

The  $d_{50}$  value indicates that 50% by weight of the particles have a diameter smaller than that figure. The particle size may, in particular be determined by conventional analytical techniques such as microscopic determination using a scanning electron microscope or by means of a laser granulometer. Other methods of establishing  $d_{50}$  values are disclosed in EP 384070A.

#### Heavy metal ion sequestrant

The detergent compositions of the invention preferably contain as an optional component a heavy metal ion sequestrant. By heavy metal ion sequestrant it is meant herein components which act to sequester (chelate) heavy metal ions. These components may also have calcium and magnesium chelation capacity, but preferentially they show

selectivity to binding heavy metal ions such as iron, manganese and copper.

Heavy metal ion sequestrants are generally present at a level of from 0.005% to 20%, preferably from 0.1% to 10%, more preferably from 0.25% to 7.5% and most preferably from 0.5% to 5% by weight of the compositions.

Suitable heavy metal ion sequestrants for use herein include organic phosphonates, such as the amino alkylene poly (alkylene phosphonates), alkali metal ethane 1-hydroxy disphosphonates and nitrilo trimethylene phosphonates.

Preferred among the above species are diethylene triamine penta (methylene phosphonate), ethylene diamine tri (methylene phosphonate) hexamethylene diamine tetra (methylene phosphonate) and hydroxy-ethylene 1,1 diphosphonate.

Other suitable heavy metal ion sequestrant for use herein include nitrilotriacetic acid and polyaminocarboxylic acids such as ethylenediaminetetracetic acid, ethylenetriamine pentacetic acid, ethylenediamine disuccinic acid, ethylenediamine diglutamic acid, 2-hydroxypropylenediamine disuccinic acid or any salts thereof. Especially preferred is ethylenediamine-N,N'-disuccinic acid (EDDS) or the alkali metal, alkaline earth metal, ammonium, or substituted ammonium salts thereof, or mixtures thereof.

Other suitable heavy metal ion sequestrants for use herein are iminodiacetic acid derivatives such as 2-hydroxyethyl diacetic acid or glyceryl imino diacetic acid, described in EP-A-317,542 and EP-A-399,133. The iminodiacetic acid-N-2-hydroxypropyl sulfonic acid and aspartic acid N-carboxymethyl N-2-hydroxypropyl-3-sulfonic acid sequestrants described in EP-A-516,102 are also suitable herein. The  $\beta$ -alanine-N,N'-diacetic acid, aspartic acid-N,N'-diacetic acid, aspartic acid-N-monoacetic acid and iminodisuccinic acid sequestrants described in EP-A-509,382 are also suitable.

EP-A-476,257 describes suitable amino based sequestrants. EP-A-510,331 describes suitable sequestrants derived from collagen, keratin or casein. EP-A-528,859 describes a suitable alkyl iminodiacetic acid sequestrant. Dipicolinic acid and 2-phosphonobutane-1,2,4-tricarboxylic acid are also suitable. Glycinamide-N,N'-disuccinic acid (GADS), ethylenediamine-N,N'-diglutamic acid (EDDG) and 2-hydroxypropylenediamine-N,N'-disuccinic acid (HPDDS) are also suitable.

### Bleach catalyst

The oxygen-releasing bleach system can contain a transition metal containing bleach catalyst.

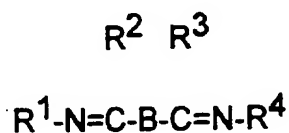
One suitable type of bleach catalyst is a catalyst system comprising a transition metal cation of defined bleach catalytic activity, such as copper, iron or manganese cations, an auxiliary metal cation having little or no bleach catalytic activity, such as zinc or aluminum cations, and a sequestrant having defined stability constants for the catalytic and auxiliary metal cations, particularly ethylenediaminetetraacetic acid, ethylenediaminetetra(methylenephosphonic acid) and water-soluble salts thereof. Such catalysts are disclosed in U.S. Pat. 4,430,243.

Other types of bleach catalysts include the manganese-based complexes disclosed in U.S. Pat. 5,246,621 and U.S. Pat. 5,244,594. Preferred examples of these catalysts include  $\text{Mn}^{\text{IV}}_2(\text{u-O})_3(1,4,7\text{-trimethyl-1,4,7-triazacyclononane})_2(\text{PF}_6)_2$ ,  $\text{Mn}^{\text{III}}_2(\text{u-O})_1(\text{u-OAc})_2(1,4,7\text{-trimethyl-1,4,7-triazacyclononane})_2(\text{ClO}_4)_2$ ,  $\text{Mn}^{\text{IV}}_4(\text{u-O})_6(1,4,7\text{-triazacyclononane})_4(\text{ClO}_4)_2$ ,  $\text{Mn}^{\text{III}}\text{Mn}^{\text{IV}}_4(\text{u-O})_1(\text{u-OAc})_2(1,4,7\text{-trimethyl-1,4,7-triazacyclononane})_2(\text{ClO}_4)_3$ , and mixtures thereof. Others are described in European patent application publication no. 549,272. Other ligands suitable for use herein include 1,5,9-trimethyl-1,5,9-triazacyclododecane, 2-methyl-1,4,7-triazacyclononane, 2-methyl-1,4,7-triazacyclononane, 1,2,4,7-tetramethyl-1,4,7-triazacyclononane, and mixtures thereof.

The bleach catalysts useful herein may also be selected as appropriate for the present invention. For examples of suitable bleach catalysts see U.S. Pat. 4,246,612 and U.S. Pat. 5,227,084. See also U.S. Pat. 5,194,416 which teaches mononuclear manganese (IV) complexes such as  $\text{Mn}(1,4,7\text{-trimethyl-1,4,7-triazacyclononane})(\text{OCH}_3)_3\text{-(PF}_6\text{)}$ .

Still another type of bleach catalyst, as disclosed in U.S. Pat. 5,114,606, is a water-soluble complex of manganese (III), and/or (IV) with a ligand which is a non-carboxylate polyhydroxy compound having at least three consecutive C-OH groups. Preferred ligands include sorbitol, iditol, dulcitol, mannitol, xylitol, arabitol, adonitol, meso-erythritol, meso-inositol, lactose, and mixtures thereof.

U.S. Pat. 5,114,611 teaches a bleach catalyst comprising a complex of transition metals, including Mn, Co, Fe, or Cu, with an non-(macro)-cyclic ligand. Said ligands are of the formula:



wherein  $\text{R}^1$ ,  $\text{R}^2$ ,  $\text{R}^3$ , and  $\text{R}^4$  can each be selected from H, substituted alkyl and aryl groups such that each  $\text{R}^1\text{-N}=\text{C}-\text{R}^2$  and  $\text{R}^3\text{-C}=\text{N}-\text{R}^4$  form a five or six-membered ring. Said ring can further be substituted. B is a bridging group selected from O, S,  $\text{CR}^5\text{R}^6$ ,  $\text{NR}^7$  and  $\text{C}=\text{O}$ , wherein  $\text{R}^5$ ,  $\text{R}^6$ , and  $\text{R}^7$  can each be H, alkyl, or aryl groups, including substituted or unsubstituted groups. Preferred ligands include pyridine, pyridazine, pyrimidine, pyrazine, imidazole, pyrazole, and triazole rings. Optionally, said rings may be substituted with substituents such as alkyl, aryl, alkoxy, halide, and nitro. Particularly preferred is the ligand 2,2'-bispyridylamine. Preferred bleach catalysts include Co, Cu, Mn, Fe, -bispyridylmethane and -bispyridylamine complexes. Highly preferred catalysts include  $\text{Co}(2,2'\text{-bispyridylamine})\text{Cl}_2$ , Di(isothiocyanato)bispyridylamine-cobalt (II), trisdipyrldylamine-cobalt(II) perchlorate,  $\text{Co}(2,2'\text{-bispyridylamine})_2\text{O}_2\text{ClO}_4$ , Bis-(2,2'-bispyridylamine) copper(II)

perchlorate, tris(di-2-pyridylamine) iron(II) perchlorate, and mixtures thereof.

Other examples include binuclear Mn complexed with tetra-N-dentate and bi-N-dentate ligands, including  $N_4Mn^{III}(u-O)_2Mn^{IV}N_4)^+$  and  $[Bipy_2Mn^{III}(u-O)_2Mn^{IV}bipy_2]-(ClO_4)_3$ .

Other bleach catalysts are described, for example, in European patent application, publication no. 408,131 (cobalt complex catalysts), European patent applications, publication nos. 384,503, and 306,089 (metallo-porphyrin catalysts), U.S. 4,728,455 (manganese/multidentate ligand catalyst), U.S. 4,711,748 and European patent application, publication no. 224,952, (absorbed manganese on aluminosilicate catalyst), U.S. 4,601,845 (aluminosilicate support with manganese and zinc or magnesium salt), U.S. 4,626,373 (manganese/ligand catalyst), U.S. 4,119,557 (ferric complex catalyst), German Pat. specification 2,054,019 (cobalt chelant catalyst) Canadian 866,191 (transition metal-containing salts), U.S. 4,430,243 (chelants with manganese cations and non-catalytic metal cations), and U.S. 4,728,455 (manganese gluconate catalysts).

The bleach catalyst is typically used in a catalytically effective amount in the compositions and processes herein. By "catalytically effective amount" is meant an amount which is sufficient, under whatever comparative test conditions are employed, to enhance bleaching and removal of the stain or stains of interest from the target substrate. The test conditions will vary, depending on the type of washing appliance used and the habits of the user. Some users elect to use very hot water; others use warm or even cold water in laundering operations. Of course, the catalytic performance of the bleach catalyst will be affected by such considerations, and the levels of bleach catalyst used in fully-formulated detergent and bleach compositions can be appropriately adjusted. As a practical matter, and not by way of limitation, the compositions and processes herein can be adjusted to provide on the order of at least one part per ten million of the active bleach catalyst species in the aqueous washing liquor, and will preferably provide from about 1 ppm to about 200 ppm of the catalyst species in the wash

liquor. To illustrate this point further, on the order of 3 micromolar manganese catalyst is effective at 40°C, pH 10 under European conditions using perborate and a bleach precursor. An increase in concentration of 3-5 fold may be required under U.S. conditions to achieve the same results.

### Enzyme

Another preferred ingredient useful in the detergent compositions or components thereof is one or more additional enzymes.

Preferred additional enzymatic materials include the commercially available lipases, cutinases, amylases, neutral and alkaline proteases, cellulases, endolases, esterases, pectinases, lactases and peroxidases conventionally incorporated into detergent compositions. Suitable enzymes are discussed in US Patents 3,519,570 and 3,533,139.

Preferred commercially available protease enzymes include those sold under the tradenames Alcalase, Savinase, Primase, Durazym, and Esperase by Novo Industries A/S (Denmark), those sold under the tradename Maxatase, Maxacal and Maxapem by Gist-Brocades, those sold by Genencor International, and those sold under the tradename Opticlean and Optimase by Solvay Enzymes. Protease enzyme may be incorporated into the compositions in accordance with the invention at a level of from 0.0001 % to 4 % active enzyme by weight of the composition.

Preferred amylases include, for example,  $\alpha$ -amylases obtained from a special strain of *B licheniformis*, described in more detail in GB-1,269,839 (Novo). Preferred commercially available amylases include for example, those sold under the tradename Rapidase by Gist-Brocades, and those sold under the tradename Termamyl and BAN by Novo Industries A/S. Amylase enzyme may be incorporated into the composition in accordance with the invention at a level of from 0.0001 % to 2 % active enzyme by weight of the composition.

Lipolytic enzyme may be present at levels of active lipolytic enzyme of from 0.0001 % to 2 % by weight, preferably 0.001 % to 1 % by weight, most preferably from 0.001 % to 0.5 % by weight of the compositions.

The lipase may be fungal or bacterial in origin being obtained, for example, from a lipase producing strain of Humicola sp., Thermomyces sp. or Pseudomonas sp. including Pseudomonas pseudoalcaligenes or Pseudomas fluorescens. Lipase from chemically or genetically modified mutants of these strains are also useful herein. A preferred lipase is derived from Pseudomonas pseudoalcaligenes, which is described in Granted European Patent, EP-B-0218272.

Another preferred lipase herein is obtained by cloning the gene from Humicola lanuginosa and expressing the gene in Aspergillus oryza, as host, as described in European Patent Application, EP-A-0258 068, which is commercially available from Novo Industri A/S, Bagsvaerd, Denmark, under the trade name Lipolase. This lipase is also described in U.S. Patent 4,810,414, Hoge-Jensen et al, issued March 7, 1989.

#### Organic polymeric compound

Organic polymeric compounds are preferred additional components of the detergent compositions or components thereof in accord with the invention, and are preferably present as components of any particulate components where they may act such as to bind the particulate component together. By organic polymeric compound it is meant herein essentially any polymeric organic compound commonly used as dispersants, and anti-redeposition and soil suspension agents in detergent compositions, including any of the high molecular weight organic polymeric compounds described as clay flocculating agents herein, not being an quaternised ethoxylated (poly) amine clay-soil removal/ anti-redeposition agent in accord with the invention.

Organic polymeric compound is typically incorporated in the detergent compositions of the invention at a level of from 0.1 % to 30 %, preferably from 0.5 % to 15 %, most preferably from 1 % to 10 % by weight of the compositions.



Examples of organic polymeric compounds include the water soluble organic homo- or co-polymeric polycarboxylic acids or their salts in which the polycarboxylic acid comprises at least two carboxyl radicals separated from each other by not more than two carbon atoms. Polymers of the latter type are disclosed in GB-A-1,596,756. Examples of such salts are polyacrylates of MWt 1000-5000 and their copolymers with maleic anhydride, such copolymers having a molecular weight of from 2000 to 100,000, especially 40,000 to 80,000.

The polyamino compounds are useful herein including those derived from aspartic acid such as those disclosed in EP-A-305282, EP-A-305283 and EP-A-351629.

Terpolymers containing monomer units selected from maleic acid, acrylic acid, polyaspartic acid and vinyl alcohol, particularly those having an average molecular weight of from 5,000 to 10,000, are also suitable herein.

Other organic polymeric compounds suitable for incorporation in the detergent compositions herein include cellulose derivatives such as methylcellulose, carboxymethylcellulose, hydroxypropylmethylcellulose and hydroxyethylcellulose.

Further useful organic polymeric compounds are the polyethylene glycols, particularly those of molecular weight 1000-10000, more particularly 2000 to 8000 and most preferably about 4000.

#### Suds suppressing system

The detergent compositions of the invention, when formulated for use in machine washing compositions, preferably comprise a suds suppressing system present at a level of from 0.01 % to 15 %, preferably from 0.05 % to 10 %, most preferably from 0.1 % to 5 % by weight of the composition.

Suitable suds suppressing systems for use herein may comprise essentially any known antifoam compound, including, for example silicone antifoam compounds and 2-alkyl alcanol antifoam compounds.

By antifoam compound it is meant herein any compound or mixtures of compounds which act such as to depress the foaming or sudsing produced by a solution of a detergent composition, particularly in the presence of agitation of that solution.

Particularly preferred antifoam compounds for use herein are silicone antifoam compounds defined herein as any antifoam compound including a silicone component. Such silicone antifoam compounds also typically contain a silica component. The term "silicone" as used herein, and in general throughout the industry, encompasses a variety of relatively high molecular weight polymers containing siloxane units and hydrocarbyl group of various types. Preferred silicone antifoam compounds are the siloxanes, particularly the polydimethylsiloxanes having trimethylsilyl end blocking units.

Other suitable antifoam compounds include the monocarboxylic fatty acids and soluble salts thereof. These materials are described in US Patent 2,954,347, issued September 27, 1960 to Wayne St. John. The monocarboxylic fatty acids, and salts thereof, for use as suds suppressor typically have hydrocarbyl chains of 10 to 24 carbon atoms, preferably 12 to 18 carbon atoms. Suitable salts include the alkali metal salts such as sodium, potassium, and lithium salts, and ammonium and alkanolammonium salts.

Other suitable antifoam compounds include, for example, high molecular weight fatty esters (e.g. fatty acid triglycerides), fatty acid esters of monovalent alcohols, aliphatic C<sub>18</sub>-C<sub>40</sub> ketones (e.g. stearone) N-alkylated amino triazines such as tri- to hexa-alkylmelamines or di- to tetra alkylamine chlortriazines formed as products of cyanuric chloride with two or three moles of a primary or secondary amine containing 1 to 24 carbon atoms, propylene oxide, bis stearic acid amide and monostearyl di-alkali metal (e.g. sodium, potassium, lithium) phosphates and phosphate esters.

A preferred suds suppressing system comprises

(a) antifoam compound, preferably silicone antifoam compound, most preferably a silicone antifoam compound comprising in combination

- (i) polydimethyl siloxane, at a level of from 50% to 99%, preferably 75% to 95% by weight of the silicone antifoam compound; and
- (ii) silica, at a level of from 1% to 50%, preferably 5% to 25% by weight of the silicone/silica antifoam compound;

wherein said silica/silicone antifoam compound is incorporated at a level of from 5% to 50%, preferably 10% to 40% by weight;

- (b) a dispersant compound, most preferably comprising a silicone glycol rake copolymer with a polyoxyalkylene content of 72-78% and an ethylene oxide to propylene oxide ratio of from 1:0.9 to 1:1.1, at a level of from 0.5% to 10%, preferably 1% to 10% by weight; a particularly preferred silicone glycol rake copolymer of this type is DCO544, commercially available from DOW Corning under the tradename DCO544;
- (c) an inert carrier fluid compound, most preferably comprising a C<sub>16</sub>-C<sub>18</sub> ethoxylated alcohol with a degree of ethoxylation of from 5 to 50, preferably 8 to 15, at a level of from 5% to 80%, preferably 10% to 70%, by weight;

A highly preferred particulate suds suppressing system is described in EP-A-0210731 and comprises a silicone antifoam compound and an organic carrier material having a melting point in the range 50°C to 85°C, wherein the organic carrier material comprises a monoester of glycerol and a fatty acid having a carbon chain containing from 12 to 20 carbon atoms. EP-A-0210721 discloses other preferred particulate suds suppressing systems wherein the organic carrier material is a fatty

acid or alcohol having a carbon chain containing from 12 to 20 carbon atoms, or a mixture thereof, with a melting point of from 45°C to 80°C.

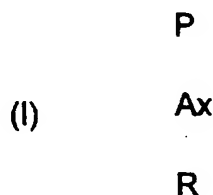
### Polymeric dye transfer inhibiting agents

The detergent compositions herein may also comprise from 0.01 % to 10 %, preferably from 0.05 % to 0.5 % by weight of polymeric dye transfer inhibiting agents.

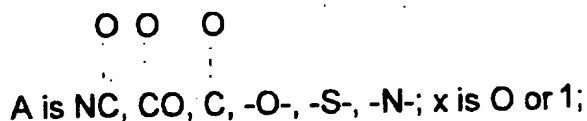
The polymeric dye transfer inhibiting agents are preferably selected from polyamine N-oxide polymers, copolymers of N-vinylpyrrolidone and N-vinylimidazole, polyvinylpyrrolidone polymers or combinations thereof, whereby these polymers can be cross-linked polymers.

#### a) Polyamine N-oxide polymers

Polyamine N-oxide polymers suitable for use herein contain units having the following structure formula :

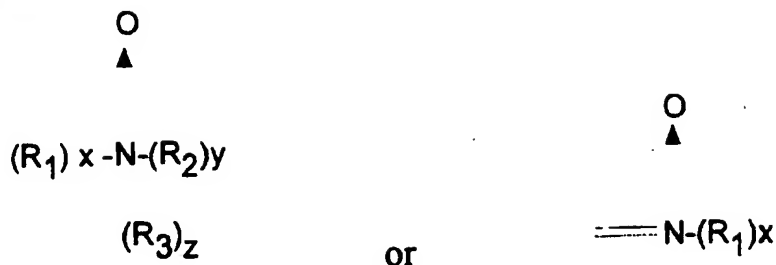


wherein P is a polymerisable unit, and



R are aliphatic, ethoxylated aliphatics, aromatic, heterocyclic or alicyclic groups or any combination thereof whereto the nitrogen of the N-O group can be attached or wherein the nitrogen of the N-O group is part of these groups.

The N-O group can be represented by the following general structures :



wherein R<sub>1</sub>, R<sub>2</sub>, and R<sub>3</sub> are aliphatic groups, aromatic, heterocyclic or alicyclic groups or combinations thereof, x or/and y or/and z is 0 or 1 and wherein the nitrogen of the N-O group can be attached or wherein the nitrogen of the N-O group forms part of these groups. The N-O group can be part of the polymerisable unit (P) or can be attached to the polymeric backbone or a combination of both.

Suitable polyamine N-oxides wherein the N-O group forms part of the polymerisable unit comprise polyamine N-oxides wherein R is selected from aliphatic, aromatic, alicyclic or heterocyclic groups. One class of said polyamine N-oxides comprises the group of polyamine N-oxides wherein the nitrogen of the N-O group forms part of the R-group. Preferred polyamine N-oxides are those wherein R is a heterocyclic group such as pyrridine, pyrrole, imidazole, pyrrolidine, piperidine, quinoline, acridine and derivatives thereof.

Other suitable polyamine N-oxides are the polyamine oxides whereto the N-O group is attached to the polymerisable unit. A preferred class of these polyamine N-oxides comprises the polyamine N-oxides having the general formula (I) wherein R is an aromatic, heterocyclic or alicyclic groups wherein the nitrogen of the N-O functional group is part of said R group. Examples of these classes are polyamine oxides wherein R is a heterocyclic compound such as pyrridine, pyrrole, imidazole and derivatives thereof.

The polyamine N-oxides can be obtained in almost any degree of polymerisation. The degree of polymerisation is not critical provided the material has the desired water-solubility and dye-suspending

power. Typically, the average molecular weight is within the range of 500 to 1000,000.

b) Copolymers of N-vinylpyrrolidone and N-vinylimidazole

Suitable herein are copolymers of N-vinylimidazole and N-vinylpyrrolidone having an average molecular weight range of from 5,000 to 50,000. The preferred copolymers have a molar ratio of N-vinylimidazole to N-vinylpyrrolidone from 1 to 0.2.

c) Polyvinylpyrrolidone

The detergent compositions herein may also utilize polyvinylpyrrolidone ("PVP") having an average molecular weight of from 2,500 to 400,000. Suitable polyvinylpyrrolidones are commercially available from ISP Corporation, New York, NY and Montreal, Canada under the product names PVP K-15 (viscosity molecular weight of 10,000), PVP K-30 (average molecular weight of 40,000), PVP K-60 (average molecular weight of 160,000), and PVP K-90 (average molecular weight of 360,000). PVP K-15 is also available from ISP Corporation. Other suitable polyvinylpyrrolidones which are commercially available from BASF Cooperation include Sokalan HP 165 and Sokalan HP 12.

d) Polyvinylloxazolidone

The detergent compositions herein may also utilize polyvinylloxazolidones as polymeric dye transfer inhibiting agents. Said polyvinylloxazolidones have an average molecular weight of from 2,500 to 400,000.

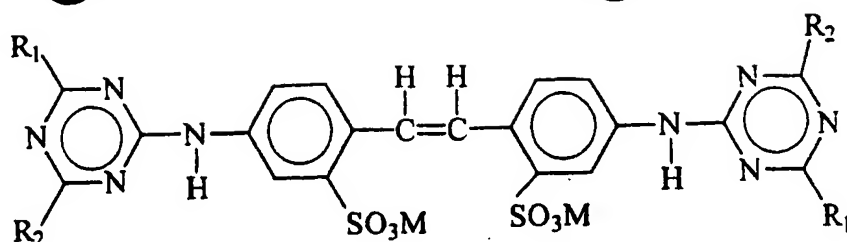
e) Polyvinylimidazole

The detergent compositions herein may also utilize polyvinylimidazole as polymeric dye transfer inhibiting agent. Said polyvinylimidazoles preferably have an average molecular weight of from 2,500 to 400,000.

Optical brightener

The detergent compositions herein also optionally contain from about 0.005% to 5% by weight of certain types of hydrophilic optical brighteners.

Hydrophilic optical brighteners useful herein include those having the structural formula:



wherein  $R_1$  is selected from anilino, N-2-bis-hydroxyethyl and NH-2-hydroxyethyl;  $R_2$  is selected from N-2-bis-hydroxyethyl, N-2-hydroxyethyl-N-methylamino, morphilino, chloro and amino; and M is a salt-forming cation such as sodium or potassium.

When in the above formula,  $R_1$  is anilino,  $R_2$  is N-2-bis-hydroxyethyl and M is a cation such as sodium, the brightener is 4,4',-bis[(4-anilino-6-(N-2-bis-hydroxyethyl)-s-triazine-2-yl)amino]-2,2'-stilbenedisulfonic acid and disodium salt. This particular brightener species is commercially marketed under the tradename Tinopal-UNPA-GX by Ciba-Geigy Corporation. Tinopal-UNPA-GX is the preferred hydrophilic optical brightener useful in the detergent compositions herein.

When in the above formula,  $R_1$  is anilino,  $R_2$  is N-2-hydroxyethyl-N-2-methylamino and M is a cation such as sodium, the brightener is 4,4'-bis[(4-anilino-6-(N-2-hydroxyethyl-N-methylamino)-s-triazine-2-yl)amino]2,2'-stilbenedisulfonic acid disodium salt. This particular brightener species is commercially marketed under the tradename Tinopal 5BM-GX by Ciba-Geigy Corporation.

When in the above formula,  $R_1$  is anilino,  $R_2$  is morphilino and M is a cation such as sodium, the brightener is 4,4'-bis[(4-anilino-6-morphilino-s-triazine-2-yl)amino]2,2'-stilbenedisulfonic acid, sodium salt. This particular brightener species is commercially marketed under the tradename Tinopal AMS-GX by Ciba Geigy Corporation.

#### Polymeric Soil Release Agent

Known polymeric soil release agents, hereinafter "SRA", can optionally be employed in the present detergent compositions. If



utilized, SRA's will generally comprise from 0.01 % to 10.0 %, typically from 0.1 % to 5 %, preferably from 0.2 % to 3.0 % by weight, of the compositions.

Preferred SRA's typically have hydrophilic segments to hydrophilize the surface of hydrophobic fibers such as polyester and nylon, and hydrophobic segments to deposit upon hydrophobic fibers and remain adhered thereto through completion of washing and rinsing cycles, thereby serving as an anchor for the hydrophilic segments. This can enable stains occurring subsequent to treatment with the SRA to be more easily cleaned in later washing procedures.

Preferred SRA's include oligomeric terephthalate esters, typically prepared by processes involving at least one transesterification/oligomerization, often with a metal catalyst such as a titanium(IV) alkoxide. Such esters may be made using additional monomers capable of being incorporated into the ester structure through one, two, three, four or more positions, without, of course, forming a densely crosslinked overall structure.

Suitable SRA's include a sulfonated product of a substantially linear ester oligomer comprised of an oligomeric ester backbone of terephthaloyl and oxyalkyleneoxy repeat units and allyl-derived sulfonated terminal moieties covalently attached to the backbone, for example as described in U.S. 4,968,451, November 6, 1990 to J.J. Scheibel and E.P. Gosselink. Such ester oligomers can be prepared by: (a) ethoxylating allyl alcohol; (b) reacting the product of (a) with dimethyl terephthalate ("DMT") and 1,2-propylene glycol ("PG") in a two-stage transesterification/oligomerization procedure; and (c) reacting the product of (b) with sodium metabisulfite in water. Other SRA's include the nonionic end-capped 1,2-propylene/polyoxyethylene terephthalate polyesters of U.S. 4,711,730, December 8, 1987 to Gosselink et al., for example those produced by transesterification/oligomerization of poly(ethyleneglycol) methyl ether, DMT, PG and poly(ethyleneglycol) ("PEG"). Other examples of SRA's include: the partly- and fully- anionic-end-capped oligomeric esters of U.S. 4,721,580, January 26, 1988 to Gosselink, such as

oligomers from ethylene glycol ("EG"), PG, DMT and Na-3,6-dioxo-8-hydroxyoctanesulfonate; the nonionic-capped block polyester oligomeric compounds of U.S. 4,702,857, October 27, 1987 to Gosselink, for example produced from DMT, methyl (Me)-capped PEG and EG and/or PG, or a combination of DMT, EG and/or PG, Me-capped PEG and Na-dimethyl-5-sulfoisophthalate; and the anionic, especially sulfoaroyl, end-capped terephthalate esters of U.S. 4,877,896, October 31, 1989 to Maldonado, Gosselink et al., the latter being typical of SRA's useful in both laundry and fabric conditioning products, an example being an ester composition made from m-sulfobenzoic acid monosodium salt, PG and DMT, optionally but preferably further comprising added PEG, e.g., PEG 3400.

SRA's also include: simple copolymeric blocks of ethylene terephthalate or propylene terephthalate with polyethylene oxide or polypropylene oxide terephthalate, see U.S. 3,959,230 to Hays, May 25, 1976 and U.S. 3,893,929 to Basadur, July 8, 1975; cellulosic derivatives such as the hydroxyether cellulosic polymers available as METHOCEL from Dow; the C<sub>1</sub>-C<sub>4</sub> alkyl celluloses and C<sub>4</sub> hydroxyalkyl celluloses, see U.S. 4,000,093, December 28, 1976 to Nicol, et al.; and the methyl cellulose ethers having an average degree of substitution (methyl) per anhydroglucose unit from about 1.6 to about 2.3 and a solution viscosity of from about 80 to about 120 centipoise measured at 20°C as a 2% aqueous solution. Such materials are available as METOLOSE SM100 and METOLOSE SM200, which are the trade names of methyl cellulose ethers manufactured by Shinetsu Kagaku Kogyo KK.

Additional classes of SRA's include: (I) nonionic terephthalates using diisocyanate coupling agents to link polymeric ester structures, see U.S. 4,201,824, Violland et al. and U.S. 4,240,918 Lagasse et al.; and (II) SRA's with carboxylate terminal groups made by adding trimellitic anhydride to known SRA's to convert terminal hydroxyl groups to trimellitate esters. With the proper selection of catalyst, the trimellitic anhydride forms linkages to the terminals of the polymer through an ester of the isolated carboxylic acid of trimellitic anhydride rather than by opening of the anhydride linkage. Either nonionic or

anionic SRA's may be used as starting materials as long as they have hydroxyl terminal groups which may be esterified. See U.S. 4,525,524 Tung et al.. Other classes include: (III) anionic terephthalate-based SRA's of the urethane-linked variety, see U.S. 4,201,824, Violland et al.;

#### Other optional ingredients

Other optional ingredients suitable for inclusion in the compositions of the invention include perfumes, colours and filler salts, with sodium sulfate being a preferred filler salt.

#### Near neutral wash pH detergent formulation

While the detergent compositions of the present invention are operative within a wide range of wash pHs (e.g. from about 5 to about 12), they are particularly suitable when formulated to provide a near neutral wash pH, i.e. an initial pH of from about 7.0 to about 10.5 at a concentration of from about 0.1 to about 2% by weight in water at 20°C. Near neutral wash pH formulations are better for enzyme stability and for preventing stains from setting. In such formulations, the wash pH is preferably from about 7.0 to about 10.5, more preferably from about 8.0 to about 10.5, most preferably from 8.0 to 9.0.

Preferred near neutral wash pH detergent formulations are disclosed to European Patent Application 83.200688.6, filed May 16, 1983, J.H.M. Wertz and P.C.E. Goffinet.

Highly preferred compositions of this type also preferably contain from about 2 to about 10% by weight of citric acid and minor amounts (e.g., less than about 20% by weight) of neutralizing agents, buffering agents, phase regulants, hydrotropes, enzymes, enzyme stabilizing agents, polyacids, suds regulants, opacifiers, anti-oxidants, bactericides, dyes, perfumes and brighteners, such as those described in US Patent 4,285,841 to Barrat et al., issued August 25, 1981 (herein incorporated by reference).

### Form of the compositions

The detergent component of the invention can be made via a variety of methods, including dry-mixing and agglomerating of the various compounds comprised in the detergent component.

The detergent component preferably forms part of a detergent composition.

The compositions in accordance with the invention can take a variety of physical forms including granular, tablet, flake, pastille and bar forms. The compositions are particularly the so-called concentrated granular detergent compositions adapted to be added to a washing machine by means of a dispensing device placed in the machine drum with the soiled fabric load.

The compositions in accord with the present invention can also be used in or in combination with bleach additive compositions, for example comprising chlorine bleach.

In general, granular detergent compositions in accordance with the present invention can be made via a variety of methods including dry mixing, spray drying, agglomeration and granulation. The quaternised clay-soil removal/ anti-redeposition agent in accord with the present invention can be added to the other detergent components by dry-mixing, agglomeration (preferably combined with a carrier material) or as a spray-dried component.

The mean particle size of the components of granular compositions in accordance with the invention, comprising the water-soluble cationic clay-soil removal/anti-redeposition compounds, should preferably be such that no more than 15% of the particles are greater than 1.8mm in diameter and not more than 15% of the particles are less than 0.25mm in diameter. Preferably the mean particle size is such that from 10% to 50% of the particles has a particle size of from 0.2mm to 0.7mm in diameter.

The term mean particle size as defined herein is calculated by sieving a sample of the composition into a number of fractions (typically 5 fractions) on a series of sieves, preferably Tyler sieves. The weight fractions thereby obtained are plotted against the aperture size of the sieves. The mean particle size is taken to be the aperture size through which 50% by weight of the sample would pass.

The bulk density of granular detergent compositions in accordance with the present invention typically have a bulk density of at least 600 g/litre, more preferably from 650 g/litre to 1200 g/litre. Bulk density is measured by means of a simple funnel and cup device consisting of a conical funnel moulded rigidly on a base and provided with a flap valve at its lower extremity to allow the contents of the funnel to be emptied into an axially aligned cylindrical cup disposed below the funnel. The funnel is 130 mm high and has internal diameters of 130 mm and 40 mm at its respective upper and lower extremities. It is mounted so that the lower extremity is 140 mm above the upper surface of the base. The cup has an overall height of 90 mm, an internal height of 87 mm and an internal diameter of 84 mm. Its nominal volume is 500 ml.

To carry out a measurement, the funnel is filled with powder by hand pouring, the flap valve is opened and powder allowed to overfill the cup. The filled cup is removed from the frame and excess powder removed from the cup by passing a straight edged implement eg; a knife, across its upper edge. The filled cup is then weighed and the value obtained for the weight of powder doubled to provide a bulk density in g/litre. Replicate measurements are made as required.

Compacted solids may be manufactured using any suitable compacting process, such as tableting, briquetting or extrusion, preferably tableting. Preferably tablets for use in dish washing processes, are manufactured using a standard rotary tableting press using compression forces of from 5 to 13 KN/cm<sup>2</sup>, more preferably from 5 to 11KN/cm<sup>2</sup> so that the compacted solid has a minimum hardness of 176N to 275N, preferably from 195N to 245N, measured by a C100 hardness test as supplied by I. Holland instruments. This process may

be used to prepare homogeneous or layered tablets of any size or shape. Preferably tablets are symmetrical to ensure the uniform dissolution of the tablet in the wash solution.

#### Laundry washing method

Machine laundry methods herein typically comprise treating soiled laundry with an aqueous wash solution in a washing machine having dissolved or dispensed therein an effective amount of a machine laundry detergent composition in accord with the invention. By an effective amount of the detergent composition it is meant from 10g to 300g of product dissolved or dispersed in a wash solution of volume from 5 to 65 litres, as are typical product dosages and wash solution volumes commonly employed in conventional machine laundry methods.

In a preferred use aspect a dispensing device is employed in the washing method. The dispensing device is charged with the detergent product, and is used to introduce the product directly into the drum of the washing machine before the commencement of the wash cycle. Its volume capacity should be such as to be able to contain sufficient detergent product as would normally be used in the washing method.

The dispensing device containing the detergent product is placed inside the drum before the commencement of the wash, before, simultaneously with or after the washing machine has been loaded with laundry. At the commencement of the wash cycle of the washing machine water is introduced into the drum and the drum periodically rotates. The design of the dispensing device should be such that it permits containment of the dry detergent product but then allows release of this product during the wash cycle in response to its agitation as the drum rotates and also as a result of its contact with the wash water.

To allow for release of the detergent product during the wash the device may possess a number of openings through which the product may pass. Alternatively, the device may be made of a material which

is permeable to liquid but impermeable to the solid product, which will allow release of dissolved product. Preferably, the detergent product will be rapidly released at the start of the wash cycle thereby providing transient localised high concentrations of product in the drum of the washing machine at this stage of the wash cycle.

Preferred dispensing devices are reusable and are designed in such a way that container integrity is maintained in both the dry state and during the wash cycle. Especially preferred dispensing devices for use with the composition of the invention have been described in the following patents; GB-B-2, 157, 717, GB-B-2, 157, 718, EP-A-0201376, EP-A-0288345 and EP-A-0288346. An article by J.Bland published in Manufacturing Chemist, November 1989, pages 41-46 also describes especially preferred dispensing devices for use with granular laundry products which are of a type commonly known as the "granulette". Another preferred dispensing device for use with the compositions of this invention is disclosed in PCT Patent Application No. WO94/11562.

Especially preferred dispensing devices are disclosed in European Patent Application Publication Nos. 0343069 & 0343070. The latter Application discloses a device comprising a flexible sheath in the form of a bag extending from a support ring defining an orifice, the orifice being adapted to admit to the bag sufficient product for one washing cycle in a washing process. A portion of the washing medium flows through the orifice into the bag, dissolves the product, and the solution then passes outwardly through the orifice into the washing medium. The support ring is provided with a masking arrangement to prevent egress of wetted, undissolved, product, this arrangement typically comprising radially extending walls extending from a central boss in a spoked wheel configuration, or a similar structure in which the walls have a helical form.

Alternatively, the dispensing device may be a flexible container, such as a bag or pouch. The bag may be of fibrous construction coated with a water impermeable protective material so as to retain the contents, such as is disclosed in European published Patent Application No.

0018678. Alternatively it may be formed of a water-insoluble synthetic polymeric material provided with an edge seal or closure designed to rupture in aqueous media as disclosed in European published Patent Application Nos. 0011500, 0011501, 0011502, and 0011968. A convenient form of water frangible closure comprises a water soluble adhesive disposed along and sealing one edge of a pouch formed of a water impermeable polymeric film such as polyethylene or polypropylene.

#### Machine dishwashing method

Any suitable methods for machine dishwashing or cleaning soiled tableware, particularly soiled silverware are envisaged.

A preferred machine dishwashing method comprises treating soiled articles selected from crockery, glassware, hollowware, silverware and cutlery and mixtures thereof, with an aqueous liquid having dissolved or dispensed therein an effective amount of a machine dishwashing composition in accord with the invention. By an effective amount of the machine dishwashing composition it is meant from 8g to 60g of product dissolved or dispersed in a wash solution of volume from 3 to 10 litres, as are typical product dosages and wash solution volumes commonly employed in conventional machine dishwashing methods.

#### Packaging for the compositions

Commercially marketed executions of the bleaching compositions can be packaged in any suitable container including those constructed from paper, cardboard, plastic materials and any suitable laminates. A preferred packaging execution is described in European Application No. 94921505.7.

#### Abbreviations used in Examples

In the detergent compositions, the abbreviated component identifications have the following meanings:

LAS : Sodium linear C<sub>12</sub> alkyl benzene sulfonate



TAS	:	Sodium tallow alkyl sulfate
CxyAS	:	Sodium C <sub>1x</sub> - C <sub>1y</sub> alkyl sulfate
C46SAS	:	Sodium C <sub>14</sub> - C <sub>16</sub> secondary (2,3) alkyl sulfate
CxyEzS	:	Sodium C <sub>1x</sub> -C <sub>1y</sub> alkyl sulfate condensed with moles of ethylene oxide
CxyEz alcohol	:	C <sub>1x</sub> -C <sub>1y</sub> predominantly linear primary condensed with an average of z moles of ethylene oxide
QAS	:	R <sub>2</sub> .N <sup>+</sup> (CH <sub>3</sub> ) <sub>2</sub> (C <sub>2</sub> H <sub>4</sub> OH) with R <sub>2</sub> = C <sub>12</sub> - C <sub>14</sub>
Soap an	:	Sodium linear alkyl carboxylate derived from 80/20 mixture of tallow and coconut oils
CFAA	:	C <sub>12</sub> -C <sub>14</sub> (coco) alkyl N-methyl glucamide
TFAA	:	C <sub>16</sub> -C <sub>18</sub> alkyl N-methyl glucamide
TPKFA	:	C <sub>12</sub> -C <sub>14</sub> topped whole cut fatty acids
STPP	:	Anhydrous sodium tripolyphosphate
TSPP	:	Tetrasodium pyrophosphate
Zeolite A	:	Hydrated Sodium Aluminosilicate of formula Na <sub>12</sub> (Al <sub>10</sub> Si <sub>2</sub> O <sub>2</sub> ) <sub>12</sub> .27H <sub>2</sub> O having a primary particle size in the range from 0.1 to 10 micrometers
Zeolite MAP	:	Hydrated sodium aluminosilicate zeolite MAP having a silicon to aluminium ratio of 1.07
NaSKS-6	:	Crystalline layered silicate of formula δ-Na <sub>2</sub> Si <sub>2</sub> O <sub>5</sub>
Citric acid	:	Anhydrous citric acid
Borate	:	Sodium borate
Carbonate size	:	Anhydrous sodium carbonate with a particle size between 200μm and 900μm
Bicarbonate	:	Anhydrous sodium bicarbonate with a particle size distribution between 400μm and 1200μm
Silicate 2.0:1)	:	Amorphous Sodium Silicate (SiO <sub>2</sub> :Na <sub>2</sub> O = 2.0:1)
Sodium sulfate	:	Anhydrous sodium sulfate

Citrate	:	Tri-sodium citrate dihydrate of activity 86.4 % with a particle size distribution between and 850 $\mu$ m
425 $\mu$ m MA/AA average AA	:	Copolymer of 1:4 maleic/acrylic acid, molecular weight about 70,000
CMC	:	Sodium polyacrylate polymer of average molecular weight 4,500
Cellulose ether	:	Sodium carboxymethyl cellulose Methyl cellulose ether with a degree of polymerization of 650 available from Shin Chemicals
Etsu Protease by	:	Proteolytic enzyme of activity 4KNPU/g sold NOVO Industries A/S under the tradename Savinase
Alcalase	:	Proteolytic enzyme of activity 3AU/g sold by NOVO Industries A/S
Cellulase sold tradename	:	Cellulytic enzyme of activity 1000 CEVU/g by NOVO Industries A/S under the Carezyme
Amylase sold by tradename	:	Amylolytic enzyme of activity 120KNU/g NOVO Industries A/S under the Termamyl 120T
Lipase  tradename	:	Lipolytic enzyme of activity 100KLU/g sold by NOVO Industries A/S under the Lipolase
Endolase CEVU/g	:	Endoglucanase enzyme of activity 3000 sold by NOVO Industries A/S
PB4 formula	:	Sodium perborate tetrahydrate of nominal NaBO <sub>2</sub> .3H <sub>2</sub> O.H <sub>2</sub> O <sub>2</sub>
PB1 nominal	:	Anhydrous sodium perborate bleach of formula NaBO <sub>2</sub> .H <sub>2</sub> O <sub>2</sub>
Percarbonate	:	Sodium percarbonate of nominal formula 2Na <sub>2</sub> CO <sub>3</sub> .3H <sub>2</sub> O <sub>2</sub>
NAC-OBS in	:	(Nonanamido caproyl) oxybenzene sulfonate the form of the sodium salt.
NACA	:	6 nonylamino - 6 oxo - capronic acid.

NOBS	:	Nonanoyloxybenzene sulfonate in the form of
the		sodium salt
TAED	:	Tetraacetylenediamine
Mn catalyst	:	Mn <sup>IV</sup> <sub>2</sub> (m-O) <sub>3</sub> (1,4,7-trimethyl-1,4,7-triazacyclononane) <sub>2</sub> (PF <sub>6</sub> ) <sub>2</sub> , as described in
U.S.		Pat. Nos. 5,246,621 and 5,244,594.
DTPA	:	Diethylene triamine pentaacetic acid
DTPMP	:	Diethylene triamine penta (methylene phosphonate), marketed by Monsanto
under the		Tradename Dequest 2060
Photoactivated	:	Sulfonated Zinc Phthlocyanine encapsulated
in bleach		dextrin soluble polymer
Brightener 1	:	Disodium 4,4'-bis(2-sulphostyry)biphenyl
Brightener 2	:	Disodium 4,4'-bis(4-anilino-6-morpholino-triazin-2-yl)amino) stilbene-2:2'-disulfonate
1.3.5-		
HEDP	:	1,1-hydroxyethane diphosphonic acid
EDDS	:	Ethylenediamine-N, N'-disuccinic acid
QEA1	:	bis((C <sub>2</sub> H <sub>5</sub> O)(C <sub>2</sub> H <sub>4</sub> O) <sub>n</sub> ) (CH <sub>3</sub> ) -N <sup>+</sup> -
C <sub>6</sub> H <sub>12</sub> -N <sup>+</sup> -		(CH <sub>3</sub> ) bis((C <sub>2</sub> H <sub>5</sub> O)-(C <sub>2</sub> H <sub>4</sub> O) <sub>n</sub> ),
wherein n = from		20 to 30
QEA2	:	bis((C <sub>2</sub> H <sub>5</sub> O)-(C <sub>2</sub> H <sub>4</sub> O) <sub>n</sub> ) (CH <sub>3</sub> ) N <sup>+</sup>
R <sub>1</sub> , wherein		R <sub>1</sub> is C <sub>4</sub> -C <sub>12</sub> alkyl group and
n = from 20 to 30		
QEA3	:	tri{(bis((C <sub>2</sub> H <sub>5</sub> O)-(C <sub>2</sub> H <sub>4</sub> O) <sub>n</sub> )(CH <sub>3</sub> )-
N <sup>+</sup> )-		(CONC <sub>3</sub> H <sub>6</sub> )}-C <sub>3</sub> H <sub>6</sub> O, wherein
n = from		20 to 26
PEGX	:	Polyethylene glycol, with a molecular weight
of x		
PEO	:	Polyethylene oxide, with a molecular weight
of		50,000
TEPAE	:	Tetraethylenepentaamine ethoxylate
PVP	:	Polyvinylpyrrolidone polymer
PVNO	:	Polyvinylpyridine N-oxide
PVPVI	:	Copolymer of polyvinylpyrrolidone and vinylimidazole

SRP 1 : Sulfobenzoyl and capped esters with  
oxyethylene oxy and terephthaloyl backbone  
SRP 2 : Diethoxylated poly (1, 2 propylene  
terephthalate) short block polymer  
Silicone antifoam : Polydimethylsiloxane foam controller with  
siloxane-oxyalkylene copolymer as dispersing  
agent with a ratio of said foam controller to  
said dispersing agent of 10:1 to 100:1  
Wax : Paraffin wax

In the following examples all levels are quoted as % by weight of the composition:

### Example 1

The following high density granular laundry detergent compositions A to F of particular utility under European machine wash conditions were prepared in accord with the invention:

	A	B	C	D	E	F
LAS	8.0	8.0	8.0	8.0	8.0	8.0
C25E3	3.4	3.4	3.4	3.4	3.4	3.4
C46AS	1.0	2.0	2.5	-	3.0	4.0
C68AS	3.0	2.0	5.0	7.0	1.0	0.5
QAS	-	-	0.8	-	-	0.8
Zeolite A	18.1	18.1	16.1	18.1	18.1	18.1
Zeolite MAP	-	4.0	3.5	-	-	-
Carbonate	13.0	13.0	13.0	27.0	27.0	27.0
Silicate	1.4	1.4	1.4	3.0	3.0	3.0

Sodium Sulfate	26.1	26.1	26.1	26.1	26.1	26.1
MA/AA	0.3	0.3	0.3	0.3	0.3	0.3
CMC	0.2	0.2	0.2	0.2	0.2	0.2
PB4	9.0	9.0	9.0	9.0	9.0	9.0
NAC OBS	2.5	1.5	3.0	4.0	3.2	2.2
Mn Catalyst	-	0.03	0.07	-	-	-
DTPMP	0.25	0.25	0.25	0.25	0.25	0.25
HEDP	0.3	0.3	0.2	0.2	0.3	0.3
EDDS	-	-	0.4	0.2	-	-
QEA 1	1.0	0.8	0.7	1.2	-	0.5
QEA 2	-	-	-	-	1.0	0.5
Protease	0.26	0.26	0.26	0.26	0.26	0.26
Amylase	0.1	0.1	0.4	0.3	0.1	0.1
Photoactivated bleach (ppm)	15 ppm	15 ppm	15 ppm	15 ppm	15 ppm	15 ppm
Brightener 1	0.09	0.09	0.09	0.09	0.09	0.09
Perfume	0.3	0.3	0.3	0.3	0.3	0.3
Silicone antifoam	0.5	0.5	0.5	0.5	0.5	0.5
Misc/minors to 100%						
Density in g/litre	850	850	850	850	850	850

**Example 2**

The following granular laundry detergent compositions G to I of particular utility under European machine wash conditions were prepared in accord with the invention:

	<b>G</b>	<b>H</b>	<b>I</b>
LAS	5.25	5.61	4.76
TAS	1.25	1.86	1.57
C45AS	-	2.24	3.89
C25E3S	-	0.76	1.18
C45E7	3.25	-	5.0
C25E3	-	5.5	-
QAS	0.8	2.0	2.0
STPP	19.7	-	-
Zeolite A	-	19.5	19.5
Zeolite MAP	2.0	-	-
NaSKS-6/citric acid (79:21)	-	10.6	10.6
Carbonate	6.1	21.4	21.4
Bicarbonate	-	2.0	2.0
Silicate	6.8	-	-
Sodium Sulfate	39.8	-	14.3
MA/AA	0.8	1.6	1.6
CMC	0.2	0.4	0.4

PB4	5.0	12.7	7.1
TAED	0.5	0.2	-
NAC OBS	1.0	1.3	3.0
DTPMP	0.25	0.2	0.2
HEDP	-	0.3	0.3
QEA 1	0.9	1.2	-
QEA 2	-	-	1.0
Protease	0.26	0.85	0.85
Lipase	0.15	0.15	0.15
Cellulase	0.28	0.28	0.28
Amylase	0.4	0.1	0.1
PVP	0.9	1.3	0.8
Photoactivated bleach (ppm)	15 ppm	27 ppm	27 ppm
Brightener 1	0.08	0.19	0.19
Brightener 2	-	0.04	0.04
Perfume	0.3	0.3	0.3
Silicone antifoam	0.5	2.4	2.4
Minors/misc to 100%			

**Example 3**

The following detergent formulations of particular utility under European machine wash conditions were prepared in accord with the invention.

	J	K	L	M
Blown powder				
LAS	6.0	5.0	11.0	6.0
TAS	2.0	-	-	2.0
Zeolite A	-	27.0	-	20.0
STPP	24.0	-	24.0	-
Sulfate	9.0	6.0	13.0	-
MA/AA	2.0	4.0	6.0	4.0
Silicate	7.0	3.0	3.0	3.0
CMC	1.0	1.0	0.5	0.6
QEA 1	0.8	1.0	1.4	0.5
QEA 2	-	-	-	0.5
Brightener	0.2	0.2	0.2	0.2
Silicone antifoam	1.0	1.0	1.0	0.3
DTPMP	0.4	0.4	0.2	0.4
Spray on				
C45E7	-	-	-	5.0
C45E2	2.5	2.5	2.0	-
C45E3	2.6	2.5	2.0	-
Perfume	0.3	0.3	0.3	0.2
Silicone antifoam	0.3	0.3	0.3	-
Dry additives				
Sulfate	3.0	3.0	5.0	10.0
Carbonate	6.0	13.0	15.0	14.0
PB1	-	-	-	1.5
PB4	18.0	18.0	10.0	18.5
NAC OBS	3.0	4.2	1.0	2.0
EDDS	-	2.0	2.4	-
Protease	1.0	1.0	1.0	1.0
Lipase	0.4	0.4	0.4	0.2



79

Amylase	0.2	0.2	0.2	0.4
Photoactivated bleach	-	-	-	0.15
Total	100.0	100.0	100.0	100.0

**Example 4**

The following granular detergent formulations were prepared in accord with the invention. Formulation N is particularly suitable for usage under Japanese machine wash conditions. Formulations O to S are particularly suitable for use under US machine wash conditions.

	N	O	P	Q	R	S
Blown powder						
LAS	22.0	5.0	4.0	9.0	8.0	7.0
C45AS	7.0	7.0	6.0	-	-	-
C46AS	-	4.0	3.0	-	-	-
C45E35	-	3.0	2.0	8.0	5.0	4.0
Zeolite A	6.0	16.0	14.0	19.0	16.0	14.0
MA/AA	6.0	3.0	3.0	-	-	-
AA	-	3.0	3.0	2.0	3.0	3.0
Sodium Sulfate	7.0	18.3	11.3	24.0	19.3	19.3
Silicate	5.0	1.0	1.0	2.0	1.0	1.0
Carbonate	28.3	9.0	7.0	25.7	8.0	6.0
QEA 1	0.9	0.9	-	-	0.5	1.1
QEA 2	-	-	0.8	1.0	-	-
QEA 3	-	-	0.4	-	-	-
PEG 4000	0.5	1.5	1.5	1.0	1.5	1.0
Sodium oleate	2.0	-	-	-	-	-
DTPA	0.4	-	0.5	-	-	0.5
Brightener	0.2	0.3	0.3	0.3	0.3	0.3
Spray on						
C25E9	1.0	-	-	-	-	-
C45E7	-	2.0	2.0	0.5	2.0	2.0
Perfume	1.0	0.3	0.3	1.0	0.3	0.3
Agglomerates						
C45AS	-	5.0	5.0	-	5.0	5.0
LAS	-	2.0	2.0	-	2.0	2.0
Zeolite A	-	7.5	7.5	-	7.5	7.5
HEDP	-	1.0	-	-	2.0	-
Carbonate	-	4.0	4.0	-	4.0	4.0

PEG 4000	-	0.5	0.5	-	0.5	0.5
Misc (water etc)	-	2.0	2.0	-	2.0	2.0
Dry additives						
NAC OBS	1.0	2.0	3.0	1.0	3.0	2.0
PB4	-	1.0	4.0	-	5.0	0.5
PB1	6.0	-	-	-	-	-
Percarbonate	-	5.0	12.5	-	-	-
Carbonate	-	5.3	1.8	-	4.0	4.0
NOBS	4.5	-	6.0	-	-	0.6
Cumeme sulfonic acid	-	2.0	2.0	-	2.0	2.0
Lipase	0.4	0.4	0.4	-	0.4	0.4
Cellulase	0.1	0.2	0.2	-	0.2	0.2
Amylase	0.1	0.3	0.3	-	-	-
Protease	1.0	0.5	0.5	0.5	0.5	0.5
PVPVI	-	0.5	0.5	-	-	-
PVP	0.5	0.5	0.5	-	-	-
PVNO	-	0.5	0.5	-	-	-
SRP1	-	0.5	0.5	-	-	-
Silicone antifoam	-	0.2	0.2	-	0.2	0.2
Total	100.0	100.0	100.0	100.0	100.0	100.0

**Example 5**

The following granular detergent formulations were prepared in accord with the invention. Formulations W and X are of particular utility under US machine wash conditions. Y is of particular utility under Japanese machine wash conditions

	T	U	V
<b>Blown Powder</b>			
Zeolite A	30.0	22.0	6.0
Sodium Sulfate	19.0	5.0	7.0
MA/AA	3.0	3.0	6.0
LAS	14.0	12.0	22.0
C45AS	8.0	7.0	7.0
Silicate	-	1.0	5.0
Soap	-	-	2.0
Brightener 1	0.2	0.2	0.2
QEA 1	0.6	2.0	1.0
Carbonate	8.0	16.0	20.0
DTPMP	-	0.4	0.4
	-	1.0	5.0
<b>Spray On</b>			
C45E7	1.0	1.0	1.0
<b>Dry additives</b>			
HEDP	1.0	-	-
PVPVI/PVNO	0.5	0.5	0.5
Protease	1.0	1.0	1.0
Lipase	0.4	0.4	0.4
Amylase	0.1	0.1	0.1
Cellulase	0.1	0.1	0.1
NAC OBS	-	6.1	4.5
PB1	11.0	5.0	6.0
Sodium Sulfate	-	6.0	-
NACA	5.0	1.0	0.8
<b>Balance (Moisture and Misc)</b>			

**Example 6**

The following granular detergent compositions of particular utility under European wash conditions were prepared in accord with the invention.

	W	X
Blown powder		
Zeolite A	20.0	-
STPP	-	20.0
LAS	6.0	6.0
C68AS	2.0	2.0
Silicate	3.0	8.0
MA/AA	4.0	2.0
CMC	0.6	0.6
QEA 1	0.9	0.6
QEA 3	0.1	-
Brightener 1	0.2	0.2
DTPMP	0.4	0.4
Spray on		
C45E7	5.0	5.0
Silicone antifoam	0.3	0.3
Perfume	0.2	0.2
Dry additives		
Carbonate	14.0	9.0
NAC OBS	6.0	2.0
NACA	-	4.0
PB4	18.5	13.0
TAED	2.0	
Photoactivated bleach	15 ppm	15 ppm
Protease	1.0	1.0
Lipase	0.2	0.2
Amylase	0.4	0.4
Cellulase	0.1	0.1
Sulfate	10.0	20.0
Balance (Moisture and Misc.)		

84

Density (g/litre)	700	700
-------------------	-----	-----

**Example 7**

The following detergent compositions, according to the present invention were prepared:

	Y	Z	AA
<b>Blown Powder</b>			
Zeolite A	15.0	15.0	15.0
Sodium Sulfate	0.0	5.0	0.0
LAS	3.0	3.0	3.0
QAS	-	1.5	1.5
DTPMP	0.4	0.2	0.4
CMC	0.4	0.4	0.4
MA/AA	4.0	2.0	2.0
<b>Agglomerates</b>			
LAS	5.0	5.0	5.0
TAS	2.0	2.0	1.0
Silicate	3.0	3.0	4.0
QEA 1	1.0	2.5	0.6
Mn Catalyst	0.03	-	-
Zeolite A	8.0	8.0	8.0
Carbonate	8.0	8.0	4.0
<b>Spray On</b>			
Perfume	0.3	0.3	0.3
C45E7	2.0	2.0	2.0
C25E3	2.0	-	-
<b>Dry additives</b>			
Citrate	5.0	-	2.0
Bicarbonate	-	3.0	-
Carbonate	8.0	15.0	10.0
NAC OBS	6.0	2.0	4.0
TAED	-	2.0	-
PB1	14.0	7.0	10.0
NACA	-	1.0	1.0
Polyethylene oxide of MW 5,000,000	-	-	0.2
Bentonite clay	-	-	10.0
EDDS	-	2.0	-

Protease	1.0	1.0	1.0
Lipase	0.4	0.4	0.4
Amylase	0.6	0.6	0.6
Cellulase	0.6	0.6	0.6
Silicone antifoam	5.0	5.0	5.0
Dry additives			
Sodium sulfate	0.0	3.0	0.0
Balance (Moisture and Misc.)	100.0	100.0	100.0
Density (g/litre)	850	850	850



**Example 8**

The following detergent formulations, according to the present invention were prepared:

	<b>BB</b>	<b>CC</b>	<b>DD</b>	<b>EE</b>
LAS	20.0	14.0	24.0	22.0
QAS	0.7	1.0	-	0.7
TFAA	-	1.0	-	-
C25E5/C45E7	-	2.0	-	0.5
C45E3S	-	2.5	-	-
STPP	30.0	18.0	30.0	22.0
Silicate	9.0	5.0	10.0	8.0
Carbonate	13.0	7.5	-	5.0
Bicarbonate	-	7.5	-	-
DTPMP	0.7	1.0	-	-
QEA 1	0.4	1.2	0.5	2.0
QEA 2	0.4	-	-	-
SRP 1	0.3	0.2	-	0.1
MA/AA	2.0	1.5	2.0	1.0
CMC	0.8	0.4	0.4	0.2
Protease	0.8	1.0	0.5	0.5
Amylase	0.8	0.4	-	0.25
Lipase	0.2	0.1	0.2	0.1
Cellulase	0.15	0.05	-	-
Photoactivated bleach (ppm)	70ppm	45ppm	-	10ppm
Brightener 1	0.2	0.2	0.08	0.2
Percarbonate	6.0	5.0	9.0	15.0
PB1	-	2.0	-	-
NAC OBS	4.2	5.0	2.0	1.0
HEDP	-	-	2.3	-
TEAD	2.0	1.0	-	-
Balance (Moisture and Miscellaneous)				

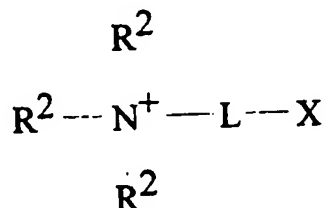
What is claimed is:

1. A granular detergent composition or component thereof comprising

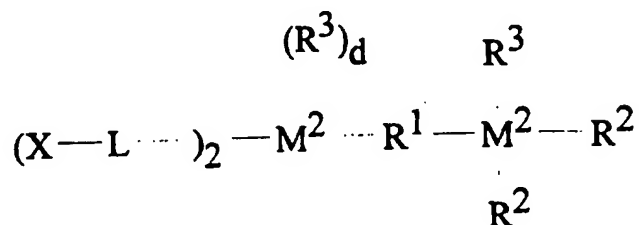
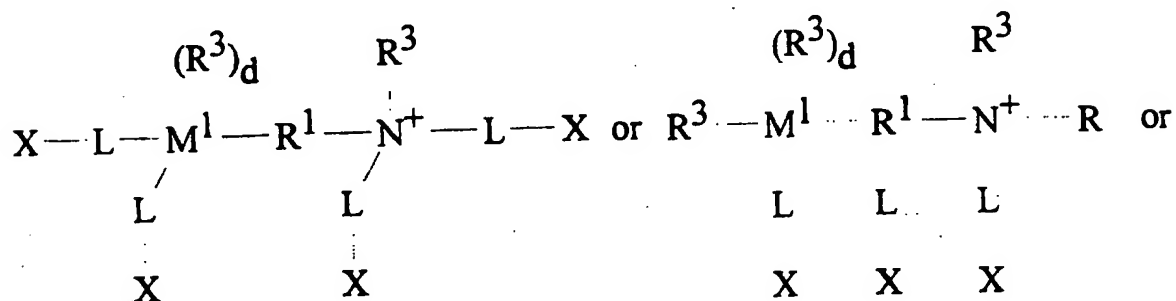
(a) a hydrophobic organic peroxyacid bleaching system, capable of providing a hydrophobic organic peroxyacid compound; and

(b) a water-soluble cationic compound having clay soil removal/anti-redeposition properties, which is selected from the group consisting of:

1) ethoxylated cationic monoamines having the formula:

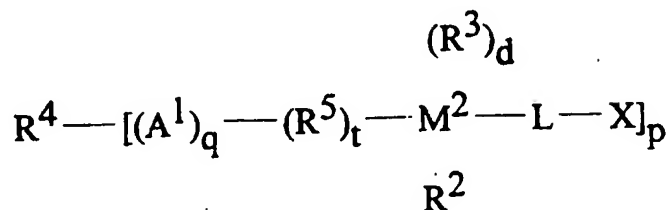


2) ethoxylated cationic diamines having the formula:

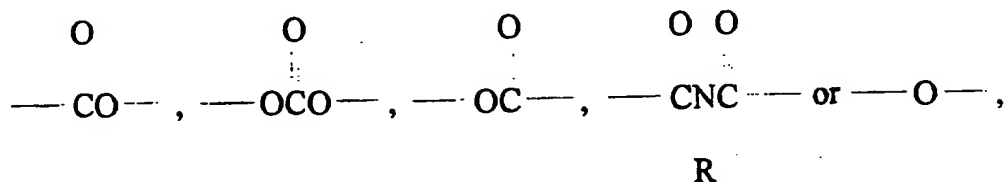
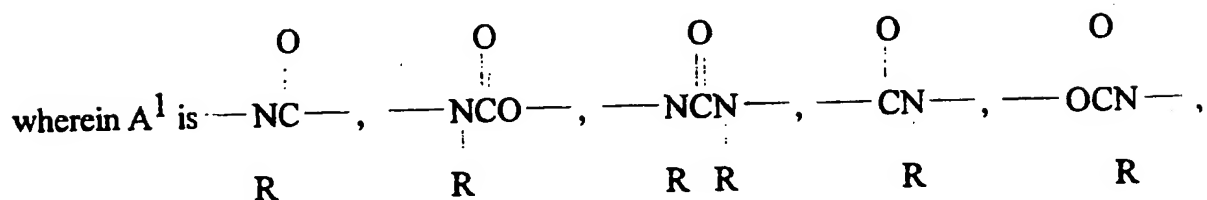


wherein  $M^1$  is an  $N^+$  or  $N$  group; each  $M^2$  is an  $N^+$  or  $N$  group, and at least one  $M^2$  is an  $N^+$  group;

3) ethoxylated cationic polyamines having the formula:



4) mixtures thereof;



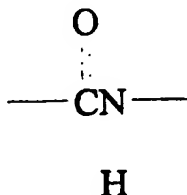
R is H or C<sub>1</sub>-C<sub>4</sub> alkyl or hydroxyalkyl, R<sup>1</sup> is C<sub>2</sub>-C<sub>12</sub> alkylene, hydroxyalkylene, alkenylene, arylene or alkarylene, or a C<sub>2</sub>-C<sub>3</sub> oxyalkylene moiety having from 2 to about 20 oxyalkylene units provided that no O-N bonds are formed; each R<sup>2</sup> is C<sub>1</sub>-C<sub>4</sub> alkyl or hydroxyalkyl, the moiety -L-X, or two R<sup>2</sup> together form the moiety -(CH<sub>2</sub>)<sub>r</sub>-A<sup>2</sup>-(CH<sub>2</sub>)<sub>s</sub>-, wherein A<sup>2</sup> is -O- or -CH<sub>2</sub>-, r is 1 or 2, s is 1 or 2 and r + s is 3 or 4; each R<sup>3</sup> is C<sub>1</sub>-C<sub>8</sub> alkyl or hydroxyalkyl, benzyl, the moiety L-X, or two R<sup>3</sup> or one R<sup>2</sup> and one R<sup>3</sup> together form the moiety -(CH<sub>2</sub>)<sub>r</sub>-A<sup>2</sup>-(CH<sub>2</sub>)<sub>s</sub>-, R<sup>4</sup> is a substituted C<sub>3</sub>-C<sub>12</sub> alkyl, hydroxyalkyl, alkenyl, aryl or alkaryl group having p substitution sites; R<sup>5</sup> is C<sub>1</sub>-C<sub>12</sub> alkenyl, hydroxyalkylene, alkenylene, arylene or alkarylene, or a C<sub>2</sub>-C<sub>3</sub> oxyalkylene moiety having from 2 to about 20 oxyalkylene units provided that no O-O or O-N bonds are formed; X is a nonionic group selected from the group consisting of

H, C<sub>1</sub>-C<sub>4</sub> alkyl or hydroxyalkyl ester or ether groups, and mixtures thereof; L is a hydrophilic chain which contains the polyoxyalkylene moiety

-[(R<sup>6</sup>O)<sub>m</sub>(CH<sub>2</sub>CH<sub>2</sub>O)<sub>n</sub>]-; wherein R<sup>6</sup> is C<sub>3</sub>-C<sub>4</sub> alkylene or hydroxyalkylene and m and n are numbers such that the moiety -(CH<sub>2</sub>CH<sub>2</sub>O)<sub>n</sub>- comprises at least about 50% by weight of said polyoxyalkylene moiety; d is 1 when M<sup>2</sup> is N<sup>+</sup> and is 0 when M<sup>2</sup> is N; n is at least about 16 for said cationic monoamines, is at least about 6 for said cationic diamines and is at least about 3 for said cationic polyamines; p is from 3 to 8; q is 1 or 0; t is 1 or 0, provided that t is 1 when q is 1.

2. A granular detergent composition according to Claim 1 wherein said cationic compound is present at a level of from 0.01% to 30% by weight of the detergent composition.
3. A granular detergent composition according to Claim 1 or 2 wherein the cationic compound is present at a level of from 0.2% to 3% by weight of the detergent composition.
4. A granular detergent composition or component thereof according to any of Claims 1 to 3 wherein said cationic compound is an ethoxylated cationic monoamine and is characterized in that one R<sup>2</sup> is methyl, two R<sup>2</sup> are the moiety L-X, m is 0 and n is at least about 20.
5. A granular detergent composition or component thereof according to any of Claims 1 to 3 wherein said cationic compound is an ethoxylated cationic diamine and is characterized in that R<sup>1</sup> is a C<sub>2</sub>-C<sub>6</sub> alkylene.
6. A granular detergent composition or component thereof according to Claim 5 wherein said ethoxylated cationic diamine is characterized in that R<sup>1</sup> is hexamethylene.

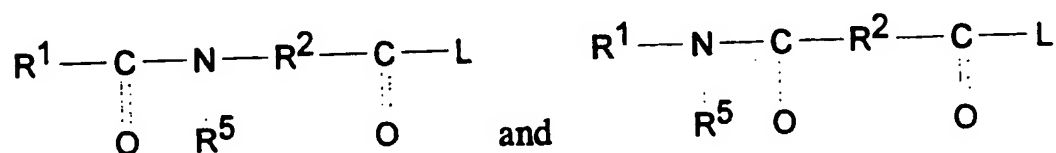
7. A granular detergent composition or component thereof according to any of Claims 5 to 6, wherein the cationic compounds is characterized in that each  $R^2$  is methyl or the moiety  $-L-X$ , each  $R^3$  is methyl and  $M^1$  and each  $M^2$  are an  $N^+$  group.
8. A granular detergent composition or component thereof according to any of Claims 5 to 7 wherein  $m$  is 0 and  $n$  is at least 12.
9. A detergent composition or component thereof according to any of Claims 1 to 3 wherein said cationic compound is an ethoxylated cationic polyamine and is characterized in that  $R^4$  is a substituted C3-C6 alkyl, hydroxyalkyl or aryl group;  $A_1$  is



and  $p$  is from 3 to 6.

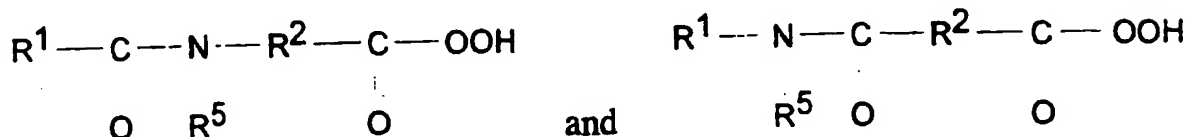
10. A granular detergent composition or component thereof according to any of Claims 5 to 7 wherein  $m$  is 0 and  $n$  is at least 20.
11. A granular detergent composition or component thereof according to any of Claims 1 to 10 wherein a cationic clay-soil removal/ anti-redeposition polymer is present characterised in that it has a backbone, at least  $2M$  groups and at least one  $L-X$  group, wherein  $M$  is a cationic group attached to or integral with the backbone and contains an  $N^+$  positively charged centre; and  $L$  connects groups  $M$  and  $X$  or connects group  $X$  to the polymer backbone;  $X$  is a nonionic group selected from the group consisting of  $H$ ,  $C_1-C_4$  alkyl or hydroxyalkyl ester or ether groups, and mixtures thereof; and  $L$  is a hydrophilic chain which contains the polyoxyalkylene moiety -  $[(R^6O)_m(CH_2CH_2O)_n]-$ ;

12. A granular detergent composition or component thereof according to Claim 11 wherein said cationic polymer is an ethoxylated cationic polymer which has a backbone, selected from the group consisting of the polyurethanes, the polyesters, the polyethers, the polyimides, the polyalkyleneimines and mixtures thereof.
13. A detergent composition or component thereof according to any of Claims 1 to 12 wherein said hydrophobic organic peroxyacid compound has at least 7 carbon atoms.
14. A detergent composition or component thereof according to any of Claims 1 or 13 wherein said hydrophobic organic peroxyacid bleaching system comprises a hydrogen peroxide source and a hydrophobic organic peroxyacid precursor.
15. A detergent composition according to Claim 14 wherein said hydrophobic organic peroxyacid precursor is present at a level of from 0.2% to 10% by weight of the detergent composition.
16. A detergent composition or component thereof according to either of Claims 14 or 15 wherein the organic peroxyacid precursor compound is an amide substituted alkyl peroxyacid precursor compound selected from the group consisting of



wherein L can be essentially any leaving group,  $\text{R}^1$  is an aryl or alkaryl group with from 1 to 14 carbon atoms,  $\text{R}^2$  is an alkylene, arylene, and alkarylene group containing from 1 to 14 carbon atoms, and  $\text{R}^5$  is H or an alkyl, aryl, or alkaryl group containing 1 to 10 carbon atoms such that  $\text{R}^1$  and  $\text{R}^5$  in total not contain more than 18 carbon.

17. A detergent composition or component thereof according to any of Claims 1 or 12 wherein said hydrophobic organic peroxyacid bleaching system comprises a preformed organic peroxyacid.
18. A detergent composition according to Claim 17 wherein said preformed organic peroxyacid is present at a level of from 1% to 10% by weight of the detergent composition.
19. A detergent composition or component thereof according to either of Claims 17 or 18 wherein the preformed organic peroxyacid is selected from the group consisting of:



wherein  $\text{R}^1$  is an aryl or alkaryl group with from about 1 to about 14 carbon atoms,  $\text{R}^2$  is an alkylene, arylene, and alkarylene group containing from about 1 to 14 carbon atoms, and  $\text{R}^5$  is H or an alkyl, aryl, or alkaryl group containing 1 to 10 carbon atoms such that  $\text{R}^1$  and  $\text{R}^5$  not contain more than 18 carbon atoms total.

20. A granular detergent composition according to any of Claims 1 to 19 wherein the composition is formulated in such a manner as to provide a wash pH of from 8.0 to 10.5.
21. A detergent composition according to any of Claims 1 to 20 wherein a heavy metal ion sequestrant is present at a level of from 0.1% to 10% by weight of the detergent composition.
22. A granular detergent composition or component thereof according to any of Claims 1 to 21 wherein a surfactant is present, selected from the group consisting of anionic, nonionic, cationic, ampholytic, amphoteric and zwitterionic surfactants and mixtures thereof.

23. A method of washing laundry in a domestic washing machine wherein an effective amount of a granular detergent composition according to any of Claims 1 to 22 is introduced into the drum of the washing machine, preferably before the commencement of the wash by use of a dispensing device which permits progressive release of said granular detergent composition into the wash liquor during the wash.



## INTERNATIONAL SEARCH REPORT

International application No.  
PCT/US97/17077

## A. CLASSIFICATION OF SUBJECT MATTER

IPC(6) :C11D 1/40, 1/44

US CL :510/299, 302, 309, 349, 350, 375, 378, 445, 446, 504

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 510/299, 302, 309, 349, 350, 375, 378, 445, 446, 504

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched  
NONEElectronic data base consulted during the international search (name of data base and, where practicable, search terms used)  
NONE

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 4,664,848 A (OH ET AL) 12 May 1987, See Abstract; column 5, line 45 to column 7, line 5; column 35, line 35 to column 36 line 15.	1-3
X	US 4,659,802 A (RUBINGH ET AL) 21 April 1987, See Abstract; column 5, line 35 to column 7, line 10; column 22, line 40 to column 23, line 50.	1-3
Y	US 4,741,842 A (ADAMS) 03 May 1988, See Abstract; column 3, lines 30-69; column 8, lines 25-60.	1-3

☐ Further documents are listed in the continuation of Box C.☐ See patent family annex.

* Special categories of cited documents:	*T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
*A* document defining the general state of the art which is not considered to be of particular relevance	*X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
*B* earlier document published on or after the international filing date	*Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
*L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	*A* document member of the same patent family
*O* document referring to an oral disclosure, use, exhibition or other means	
*P* document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search

24 NOVEMBER 1997

Date of mailing of the international search report

23 JAN 1998

Name and mailing address of the ISA/US  
Commissioner of Patents and Trademarks  
Box PCT  
Washington, D.C. 20231

Facsimile No. (703) 305-3230

Authorized officer

GREGORY R. DEL COTTO

Telephone No. (703) 308-0661

# INTERNATIONAL SEARCH REPORT

International application No.  
PCT/US97/17077

## Box I Observations where certain claims were found unsearchable (Continuation of Item 1 of first sheet)

This international report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:  
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claims Nos.:  
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:
3. ☒ Claims Nos.: 4-23  
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

## Box II Observations where unity of invention is lacking (Continuation of Item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest.  
☐ No protest accompanied the payment of additional search fees.